

FIG. 1

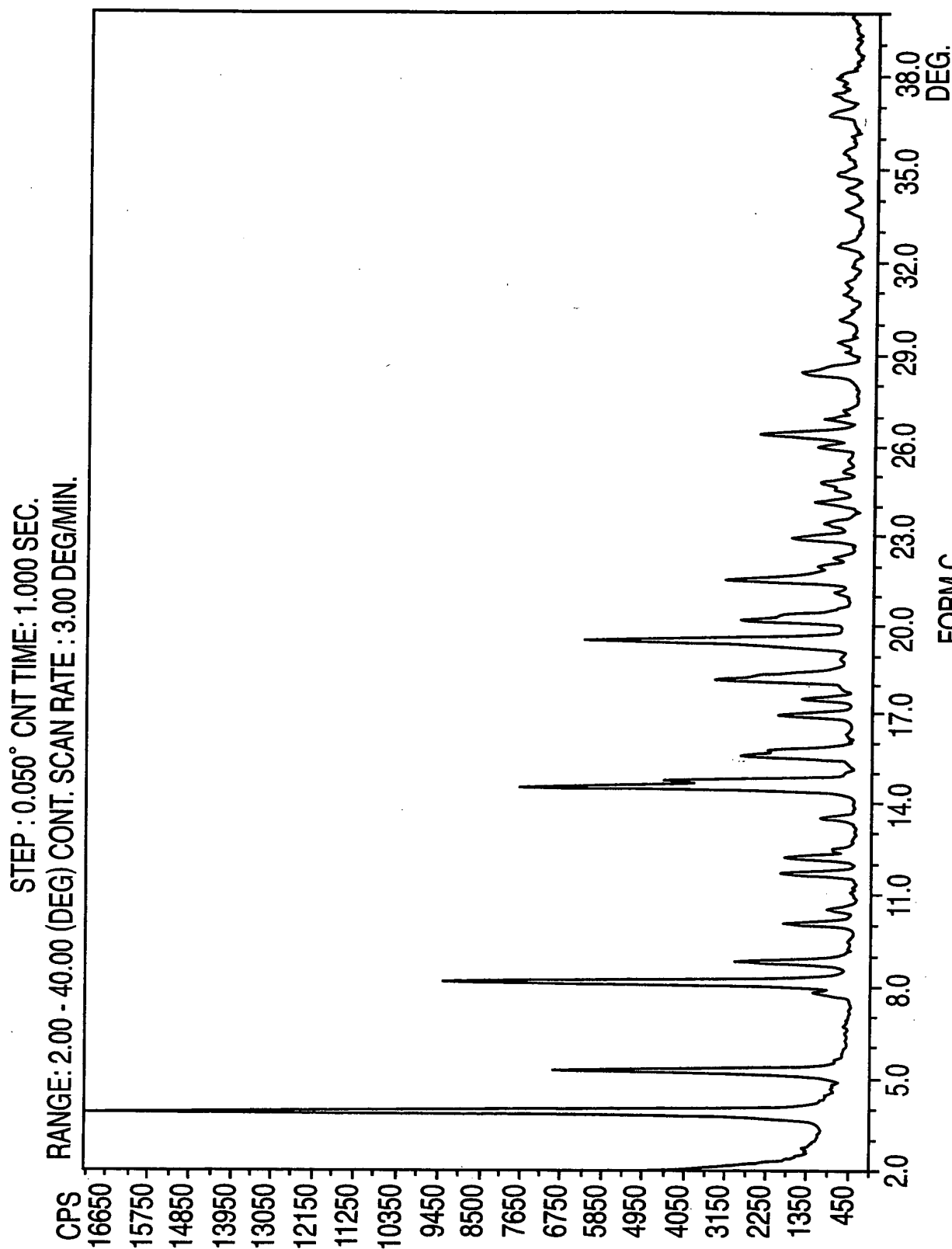


FIG. 2

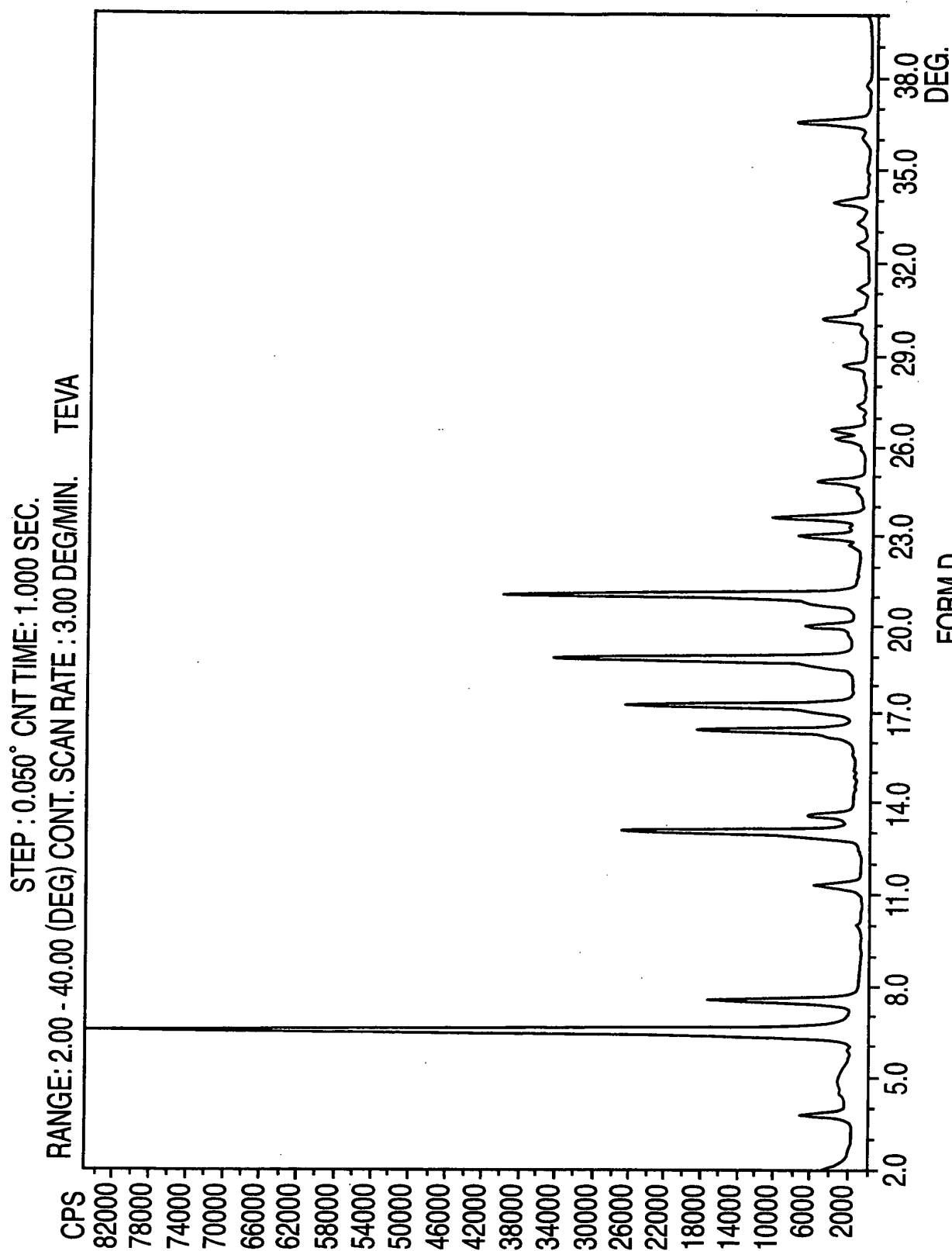
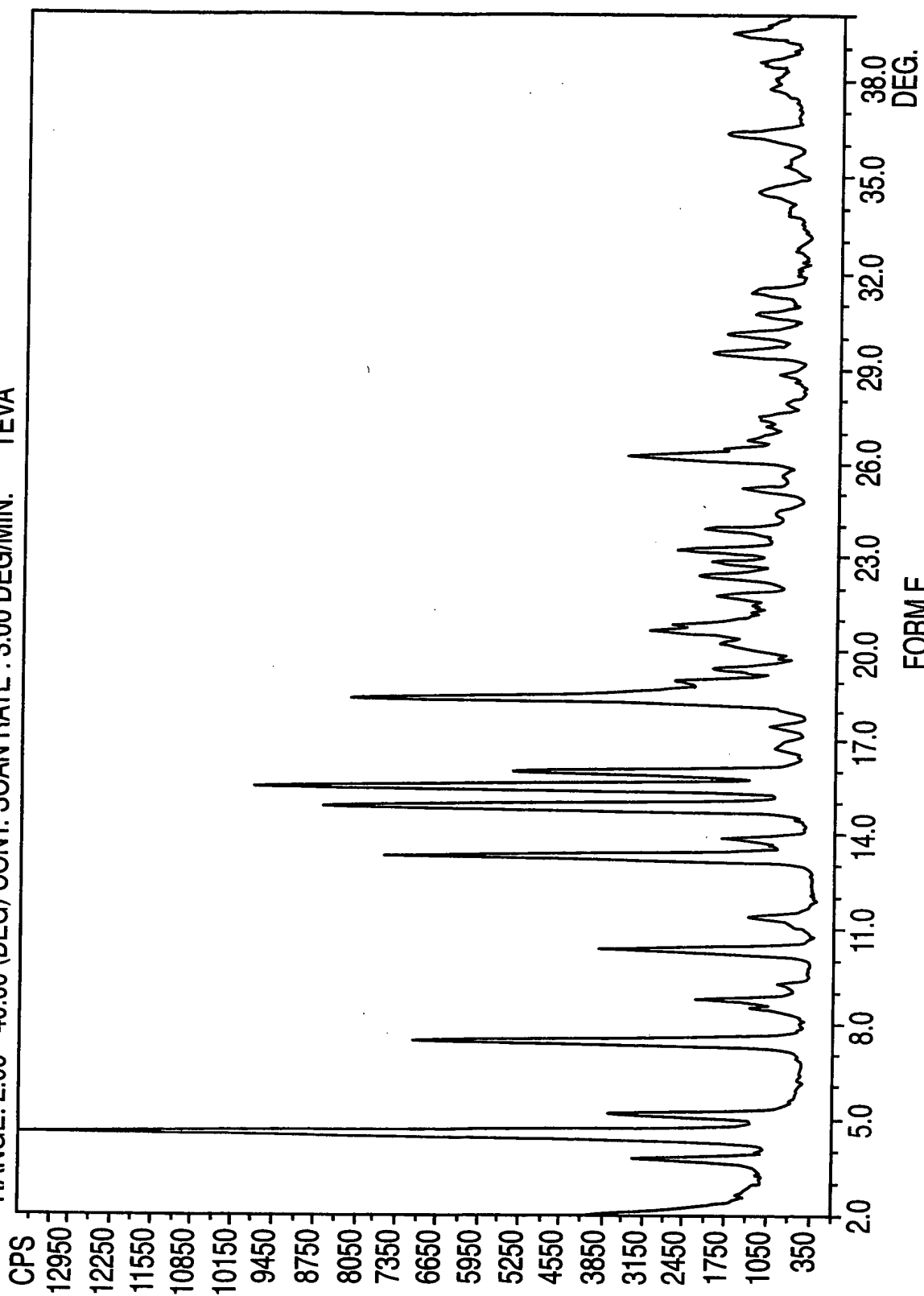


FIG. 3

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN. TEVA



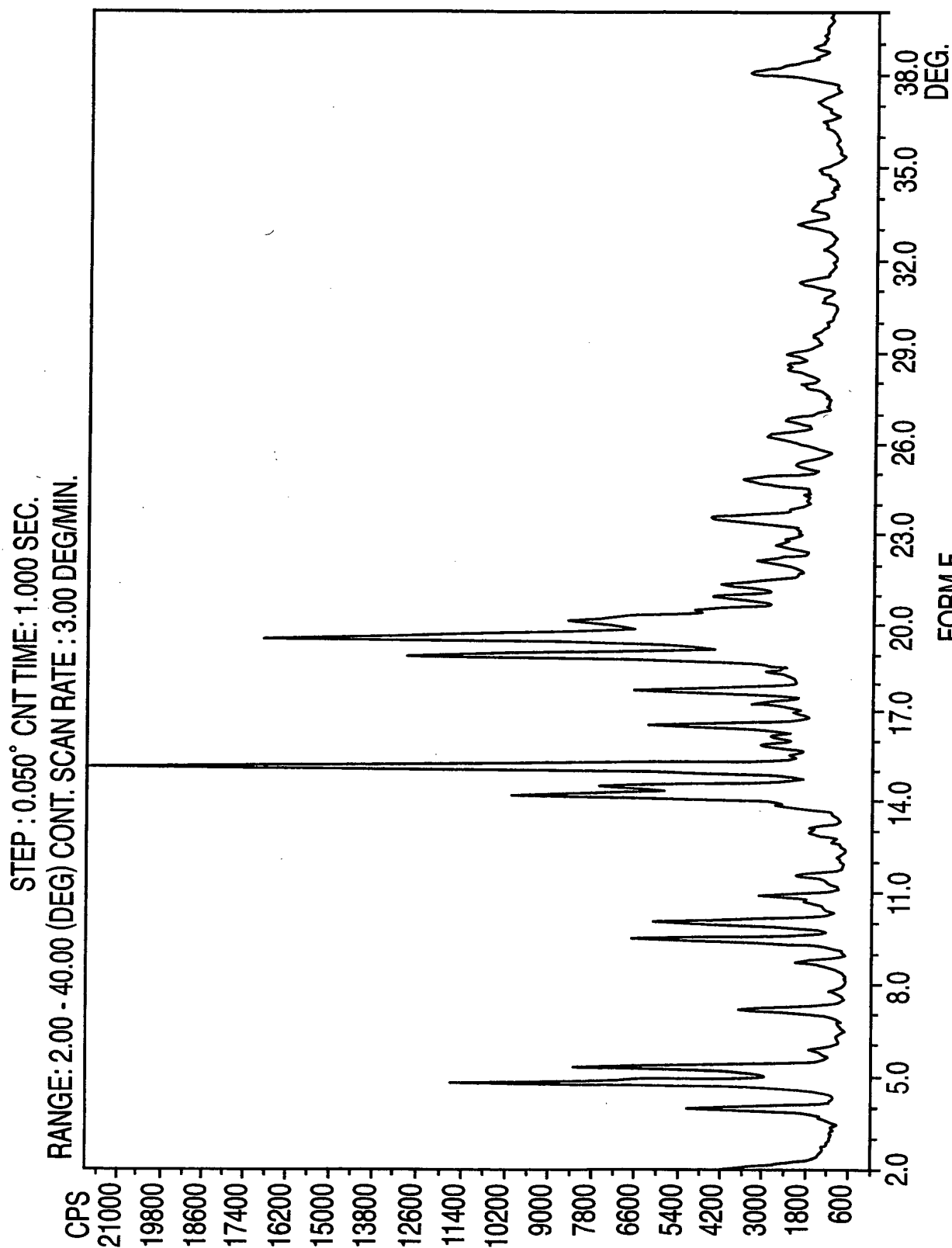
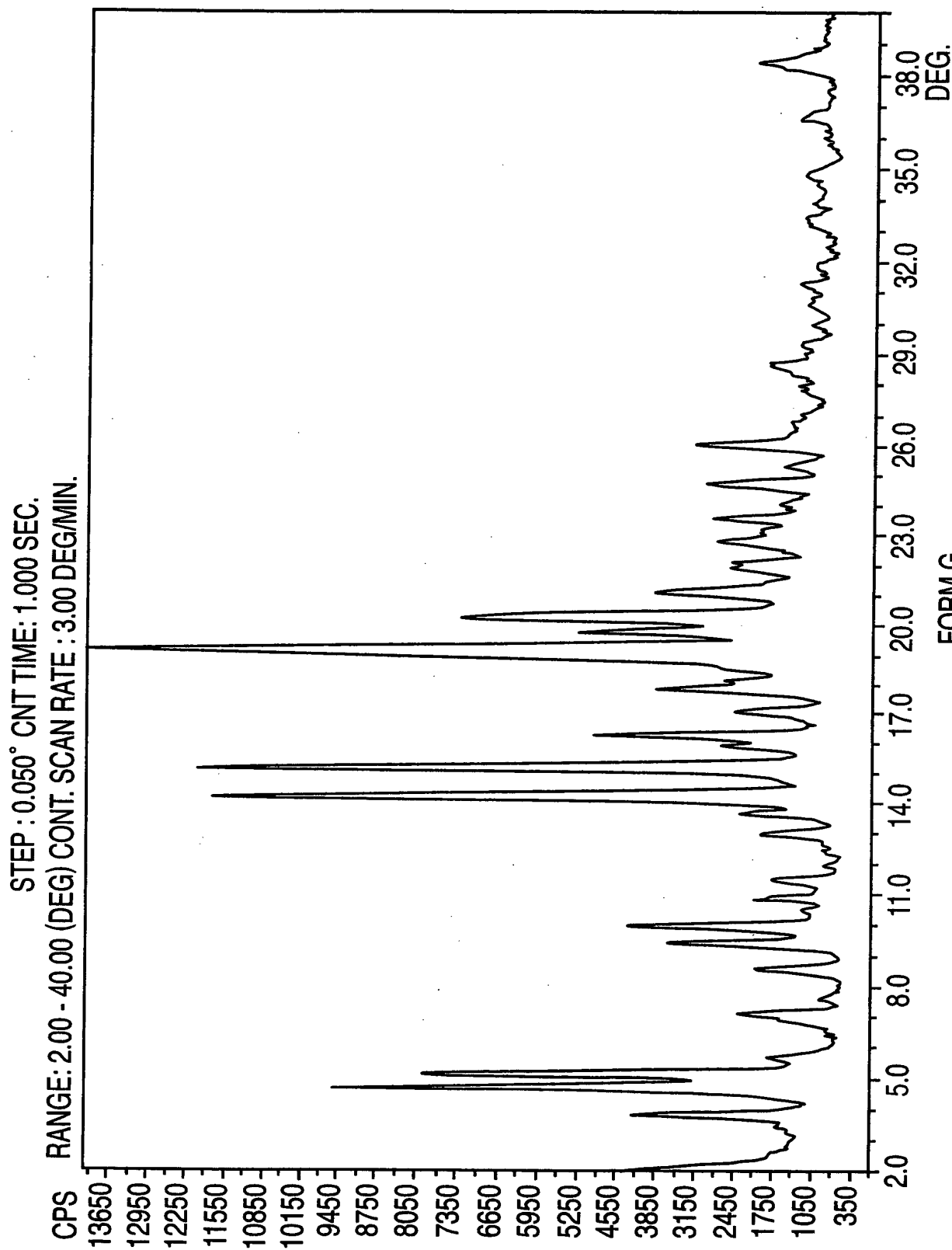
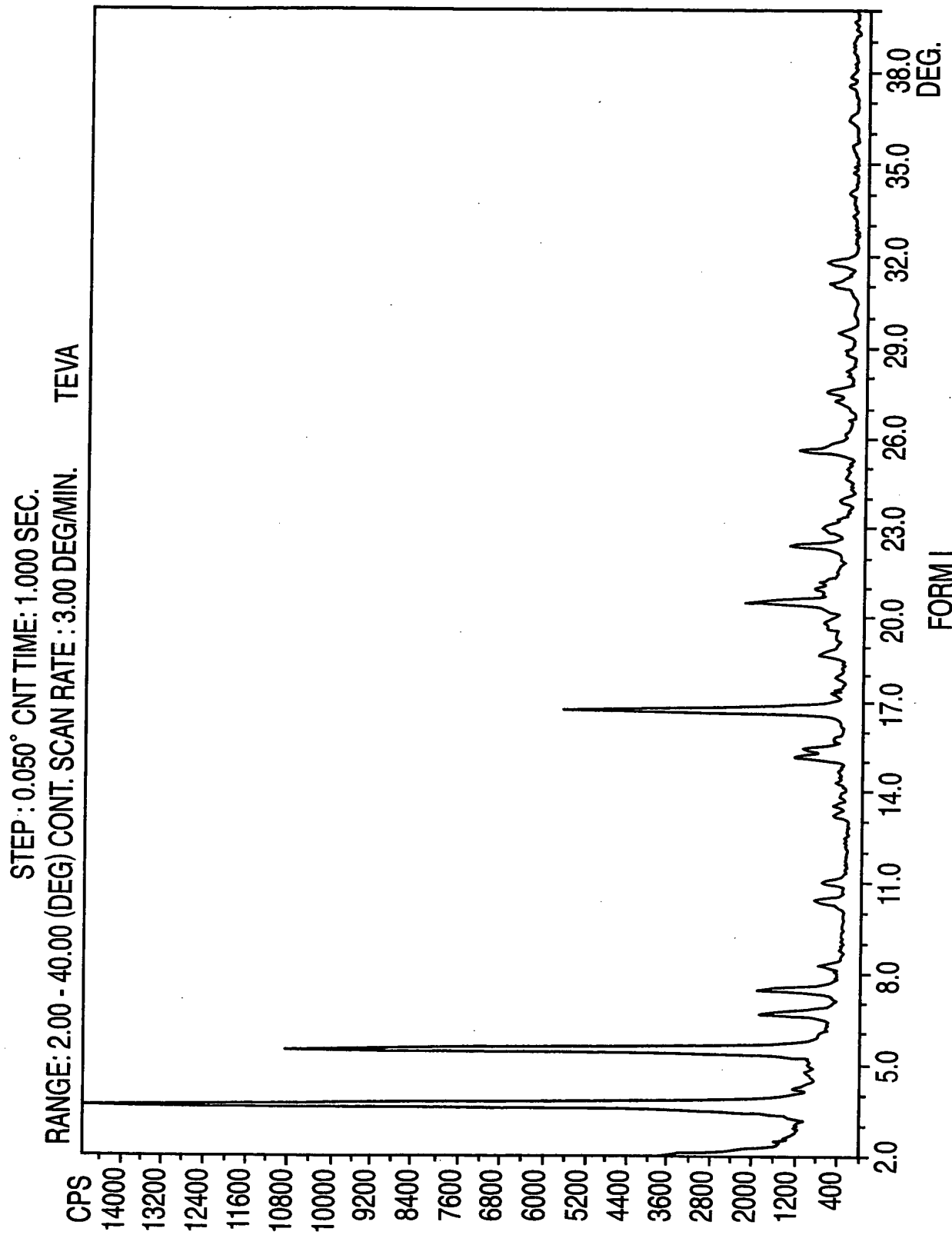


FIG. 5

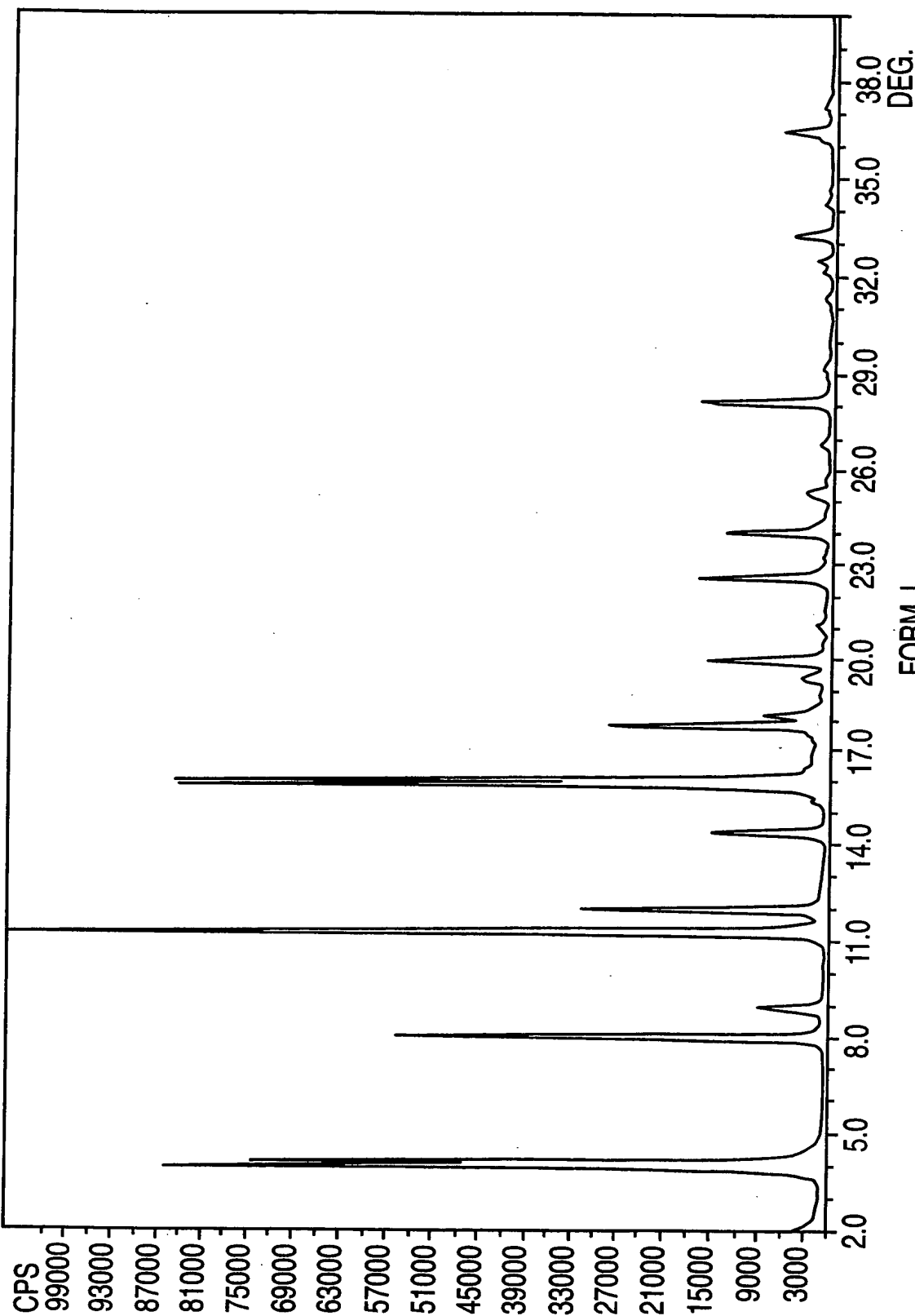


FORM G
FIG. 6



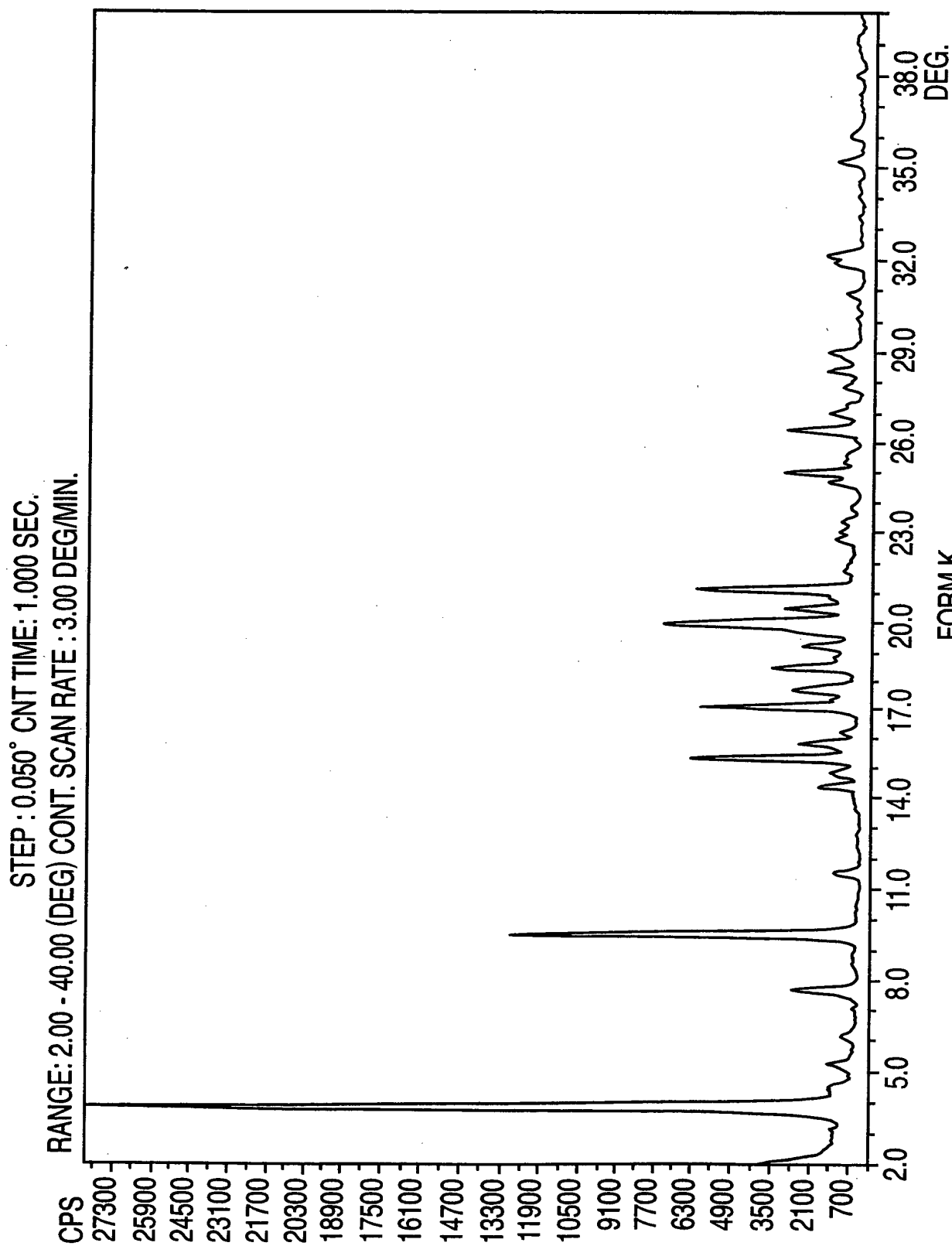
FORM I
FIG. 7

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM J

FIG. 8



FORM K
FIG. 9

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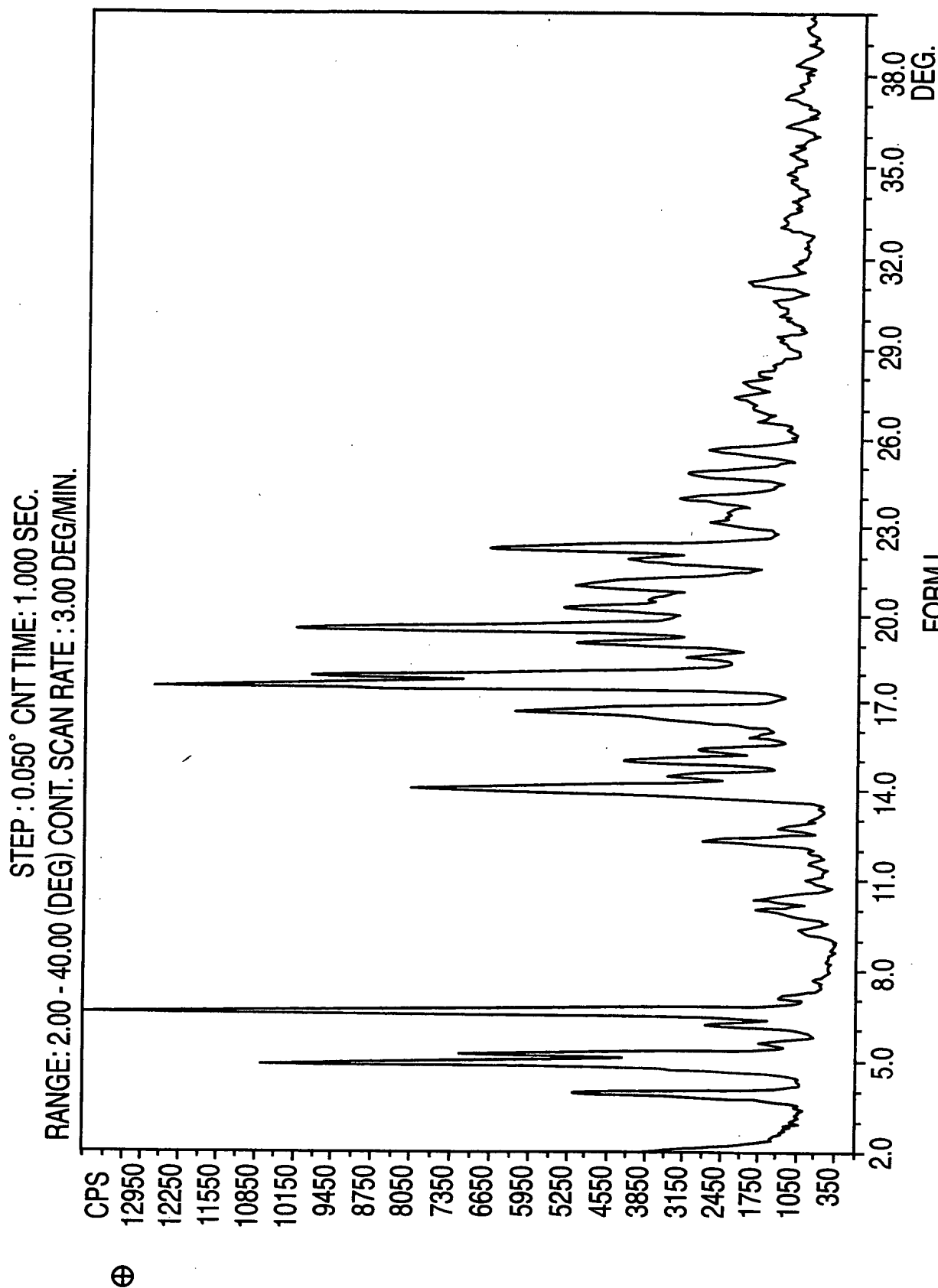
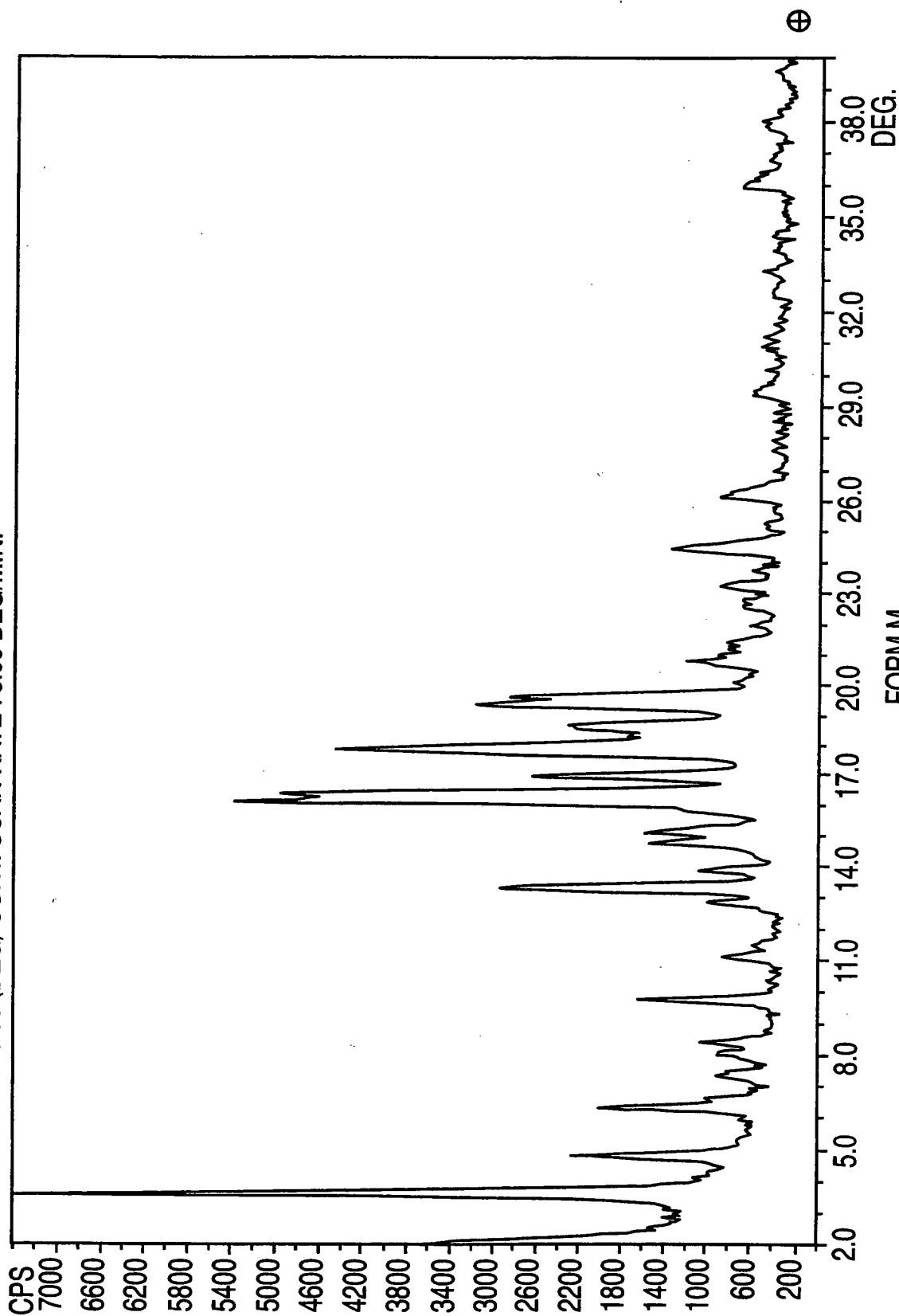


FIG. 10

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM M

FIG. 11

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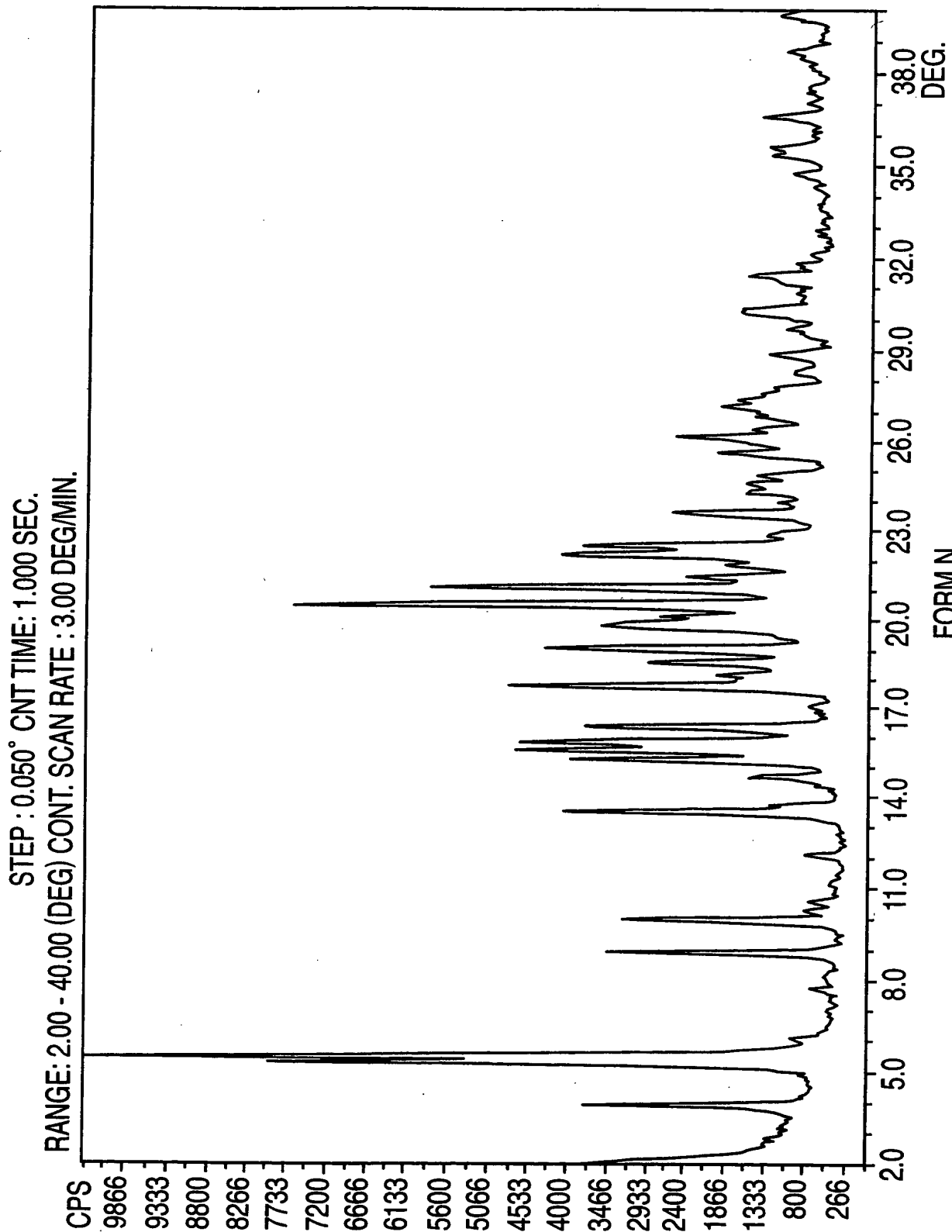
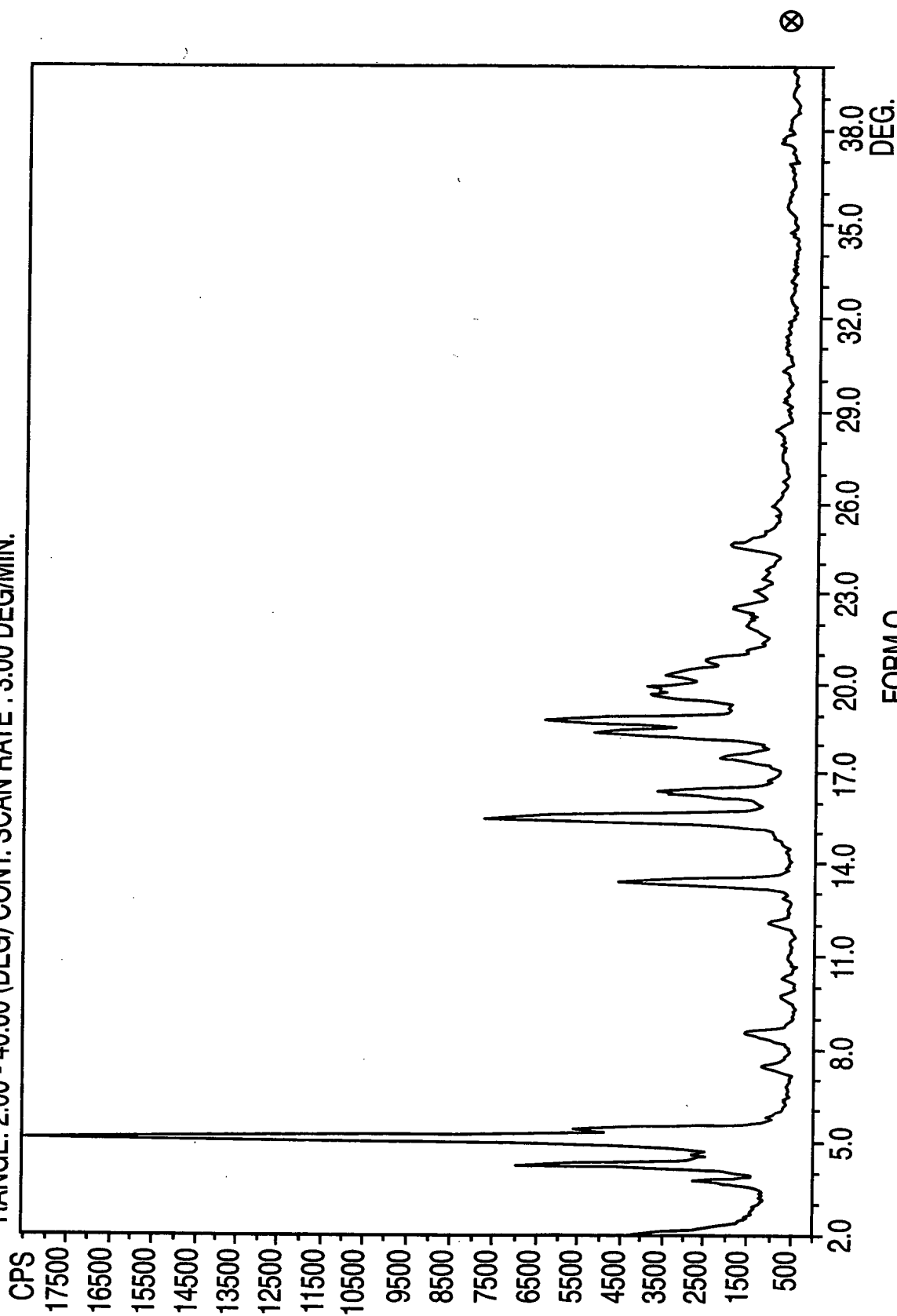


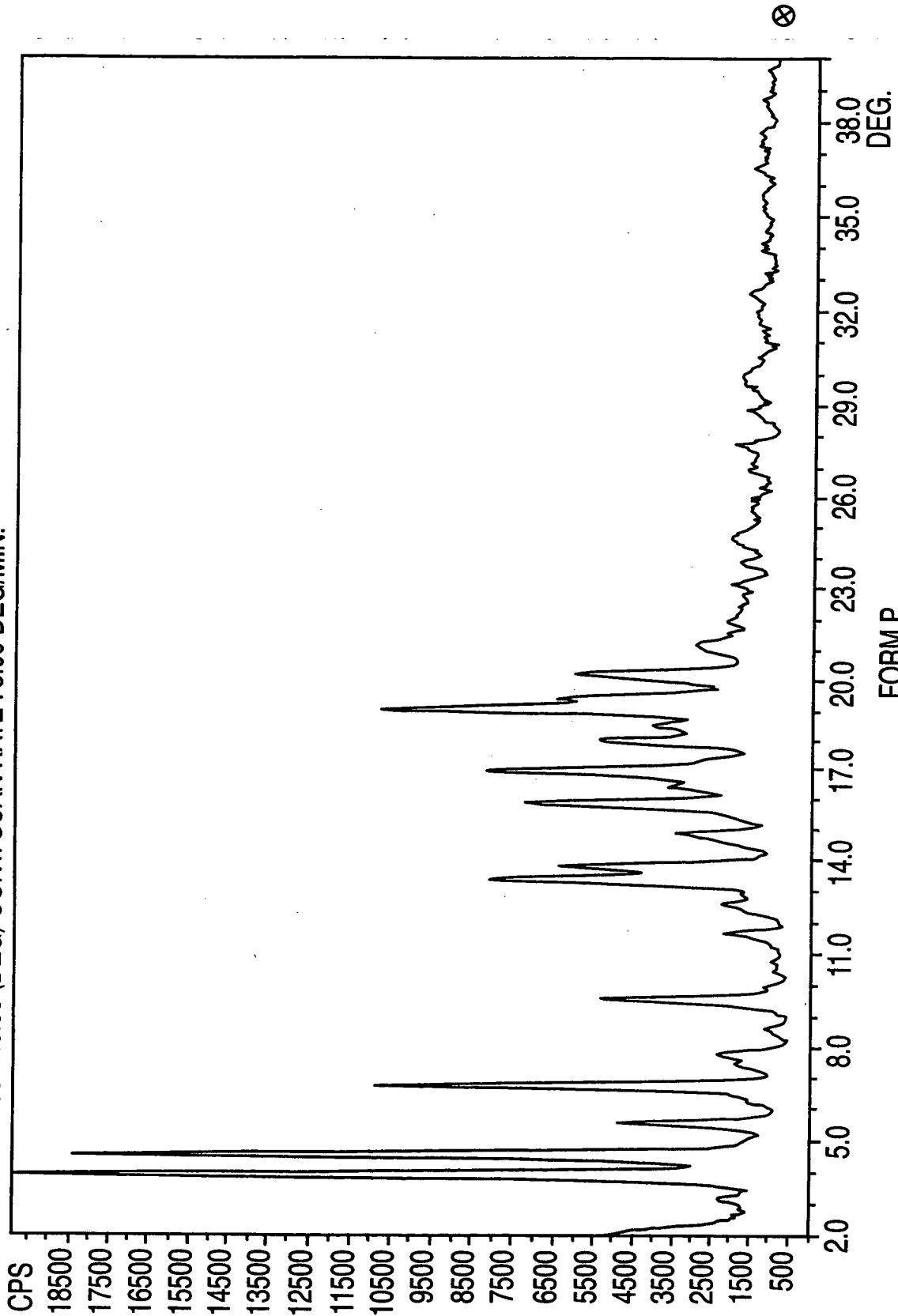
FIG. 12

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



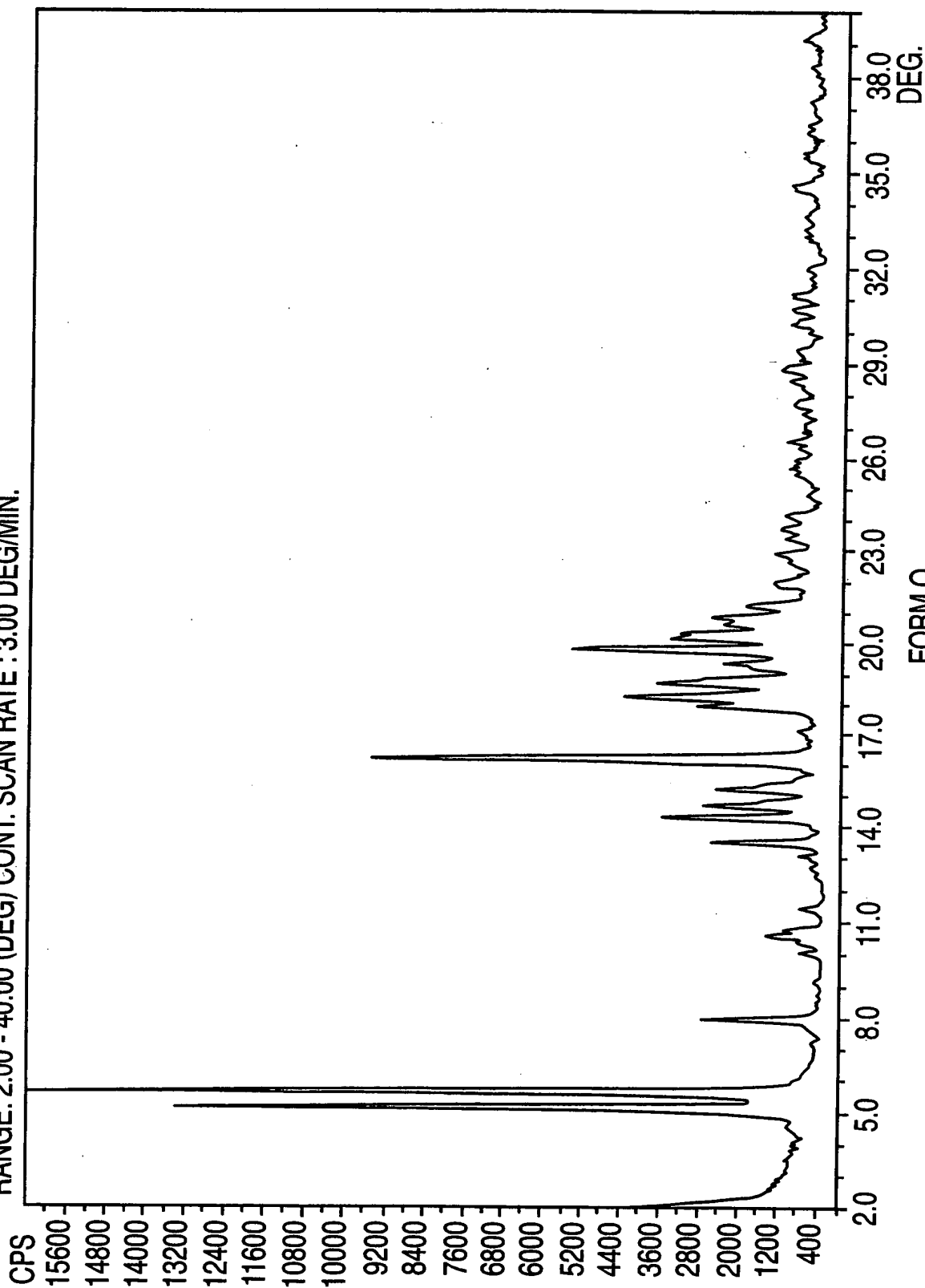
FORM 0
FIG. 13

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM P
FIG. 14

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM Q
FIG. 15

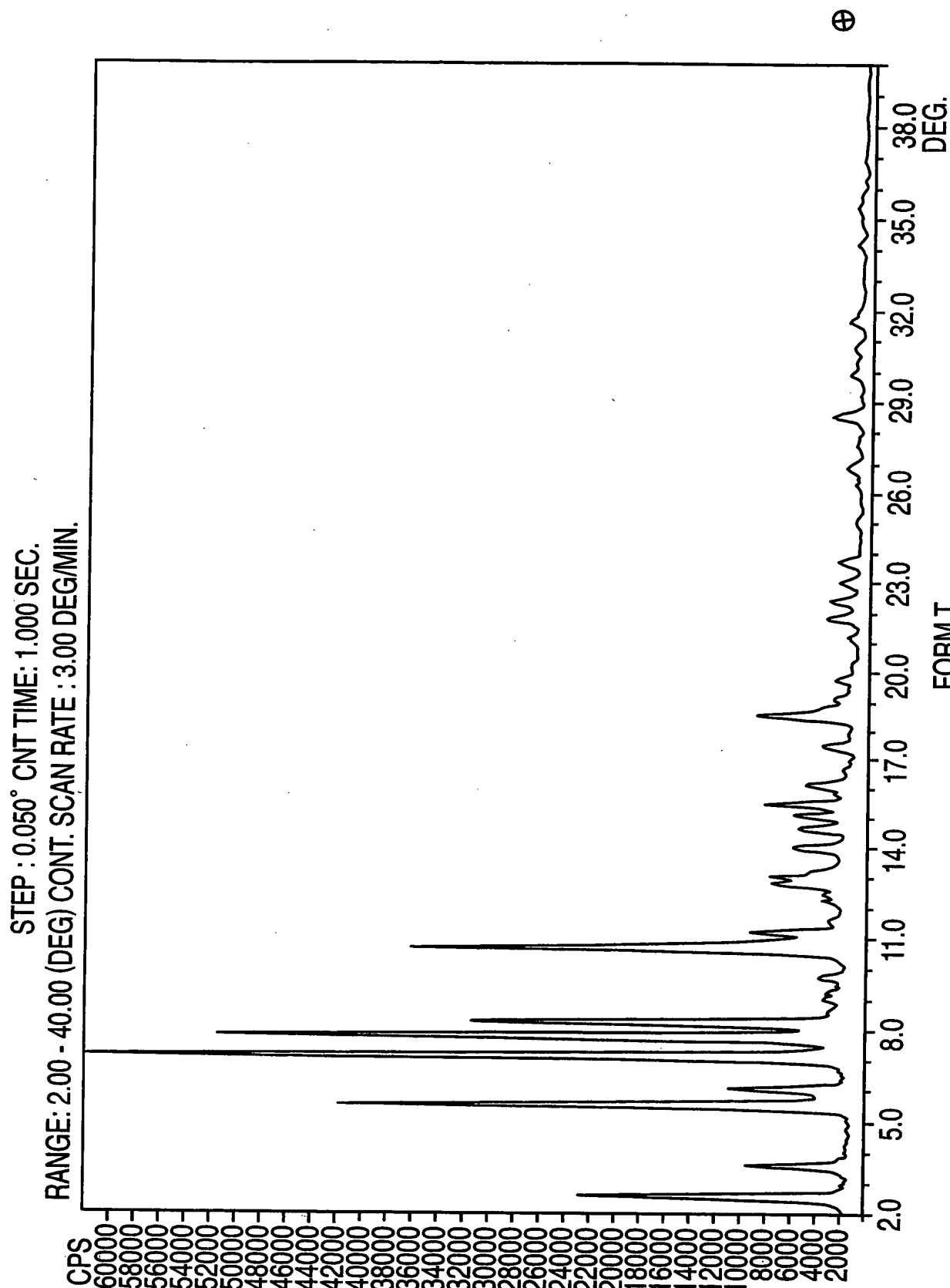
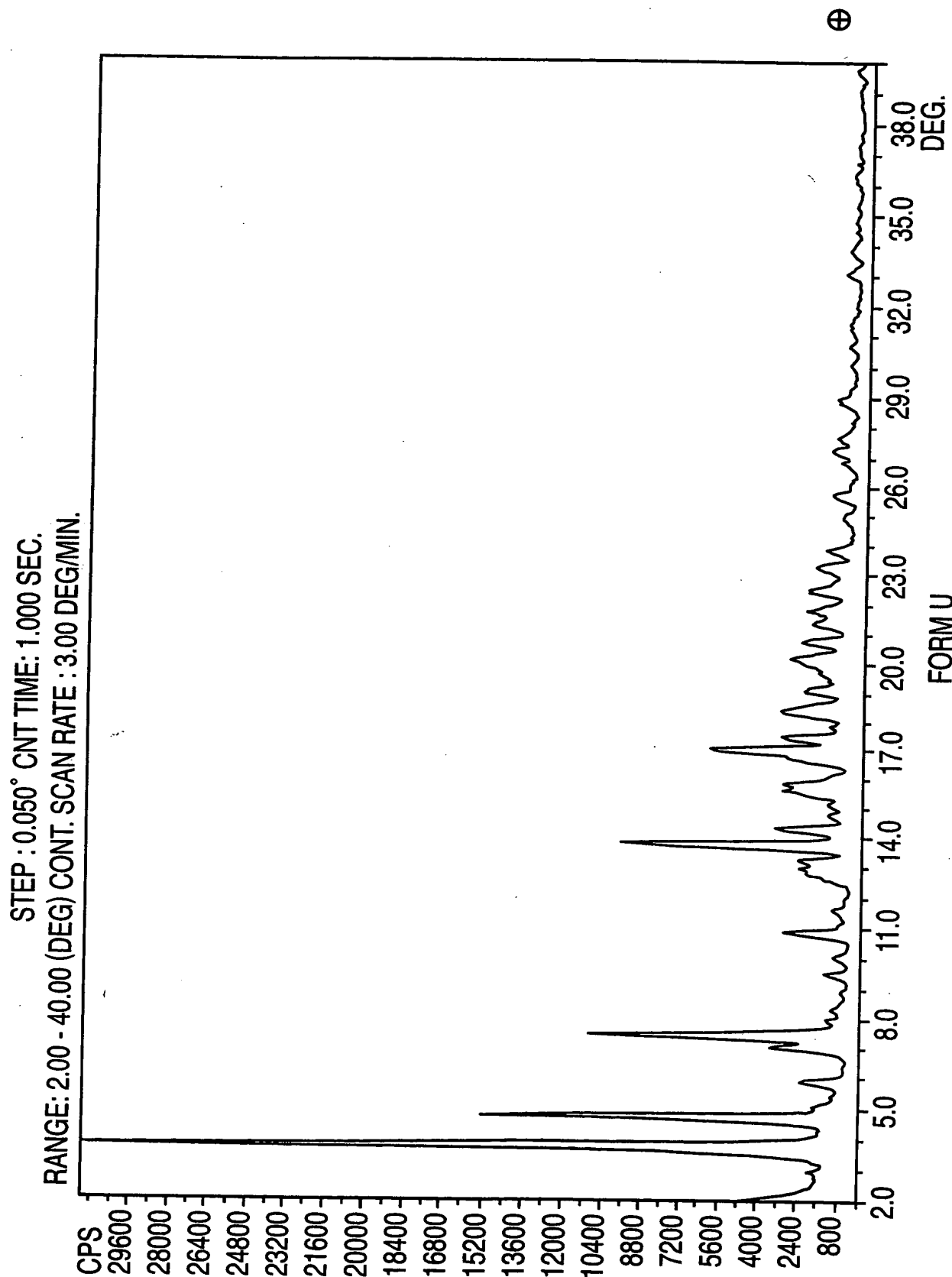


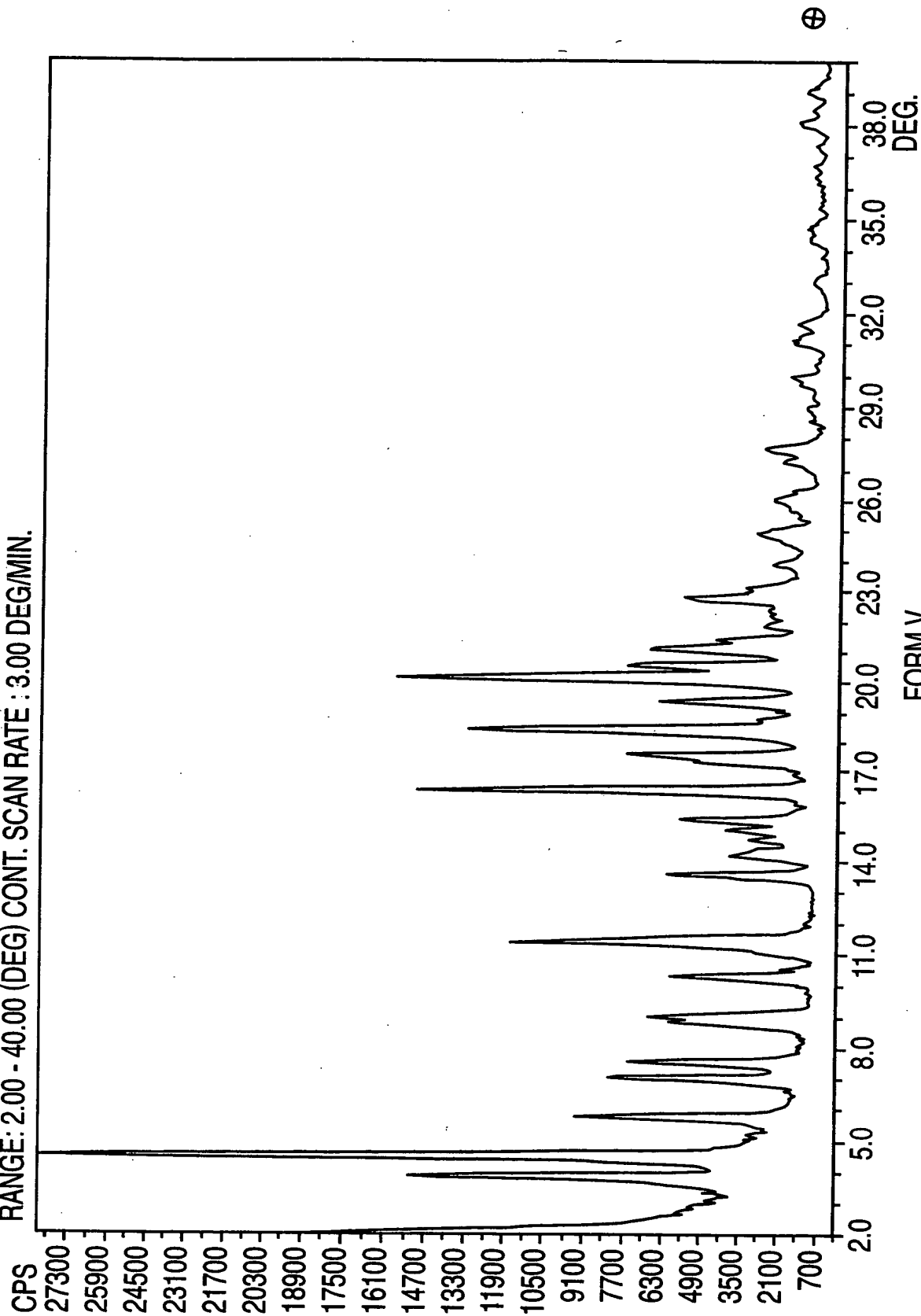
FIG. 16

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FORM U
FIG. 17

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM V

FIG. 18

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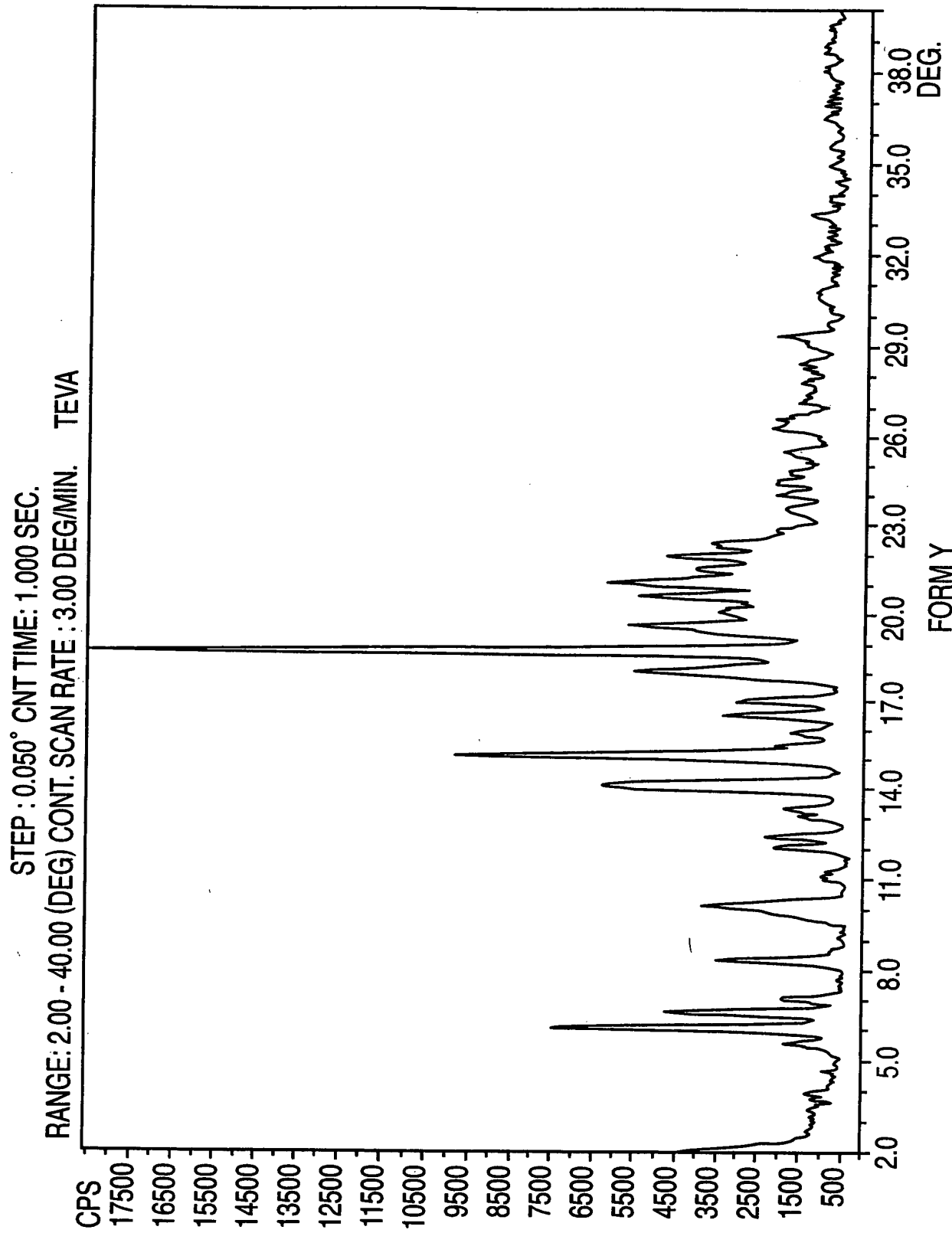


FIG. 19

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

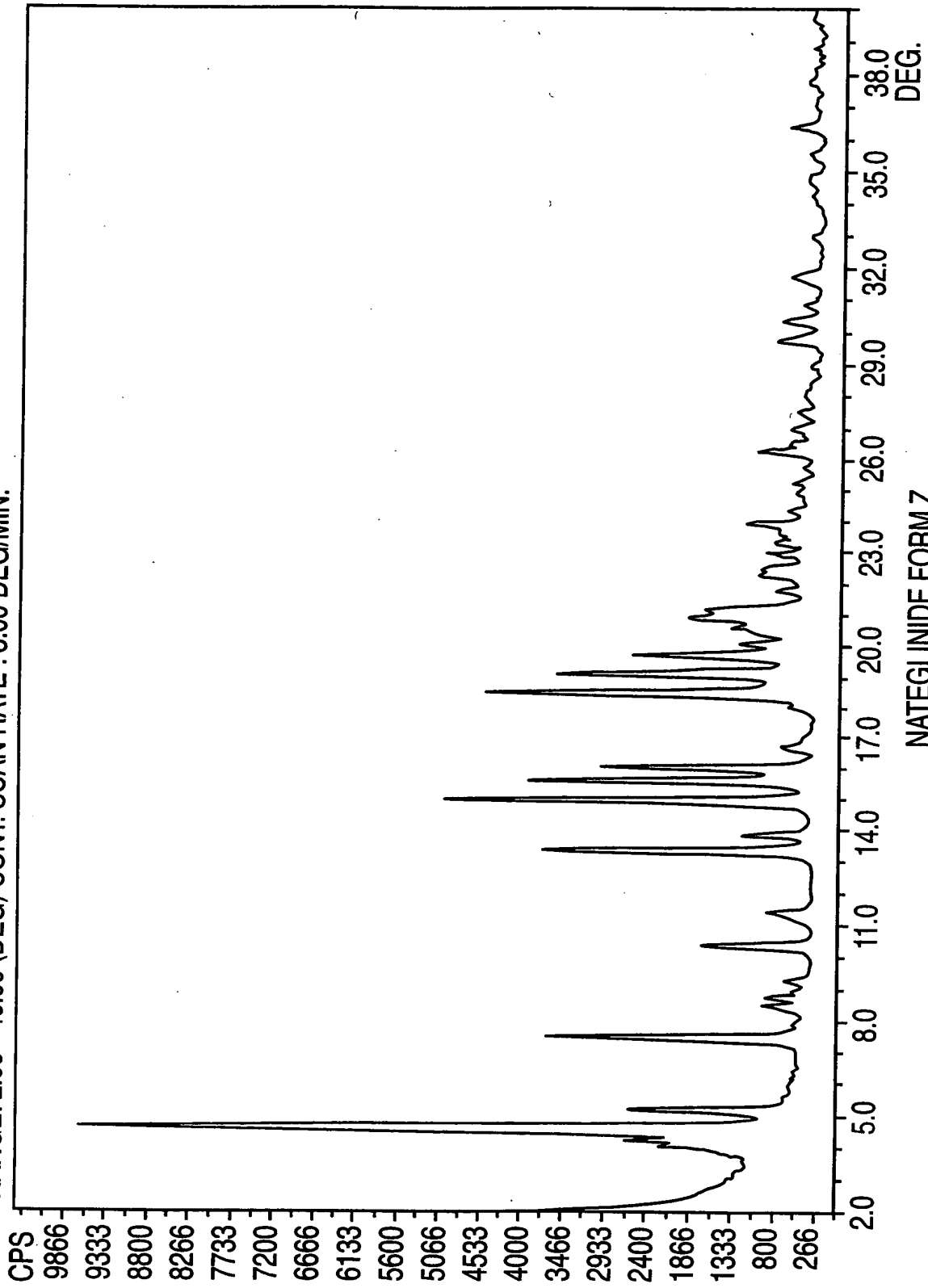


FIG. 20

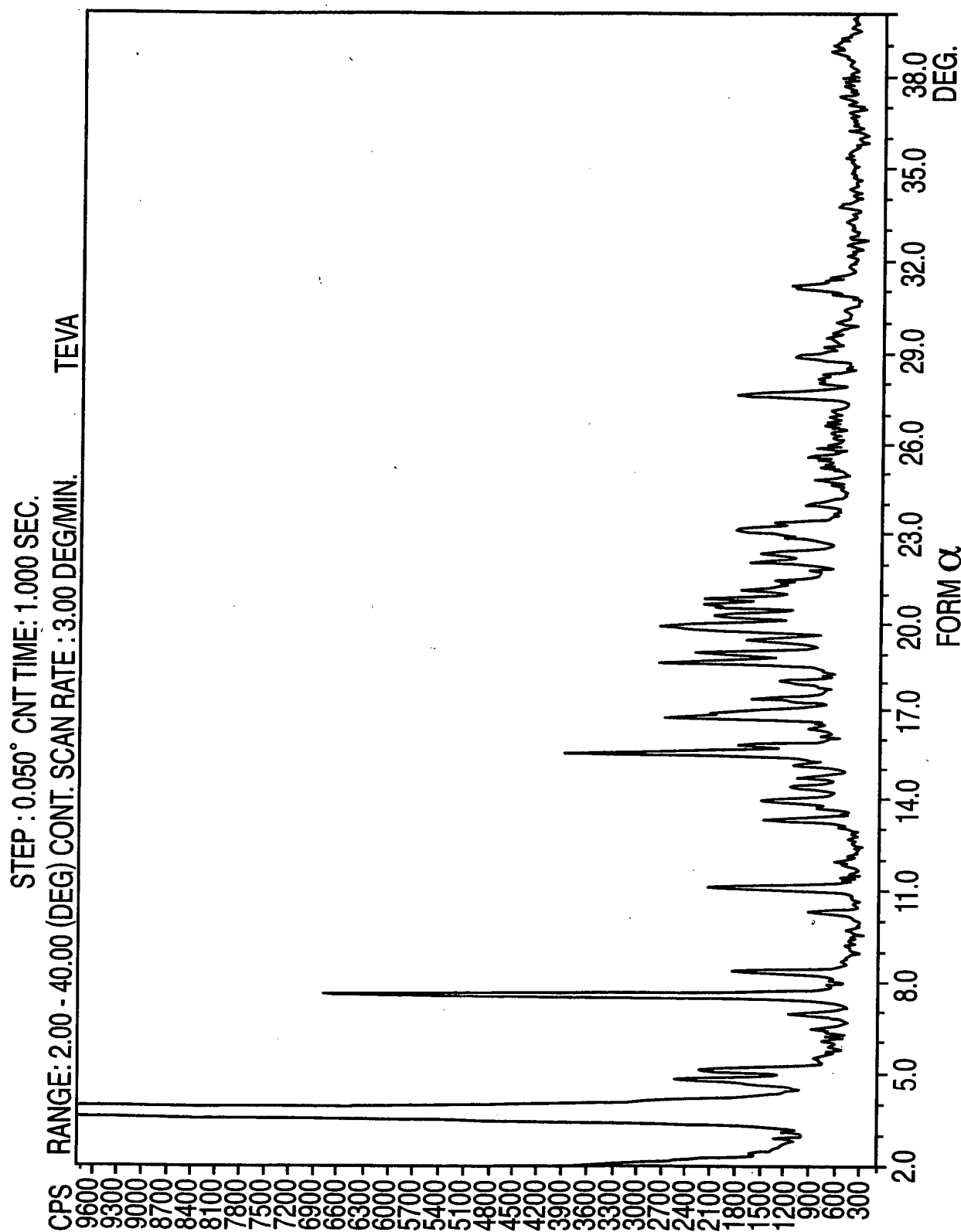


FIG. 21

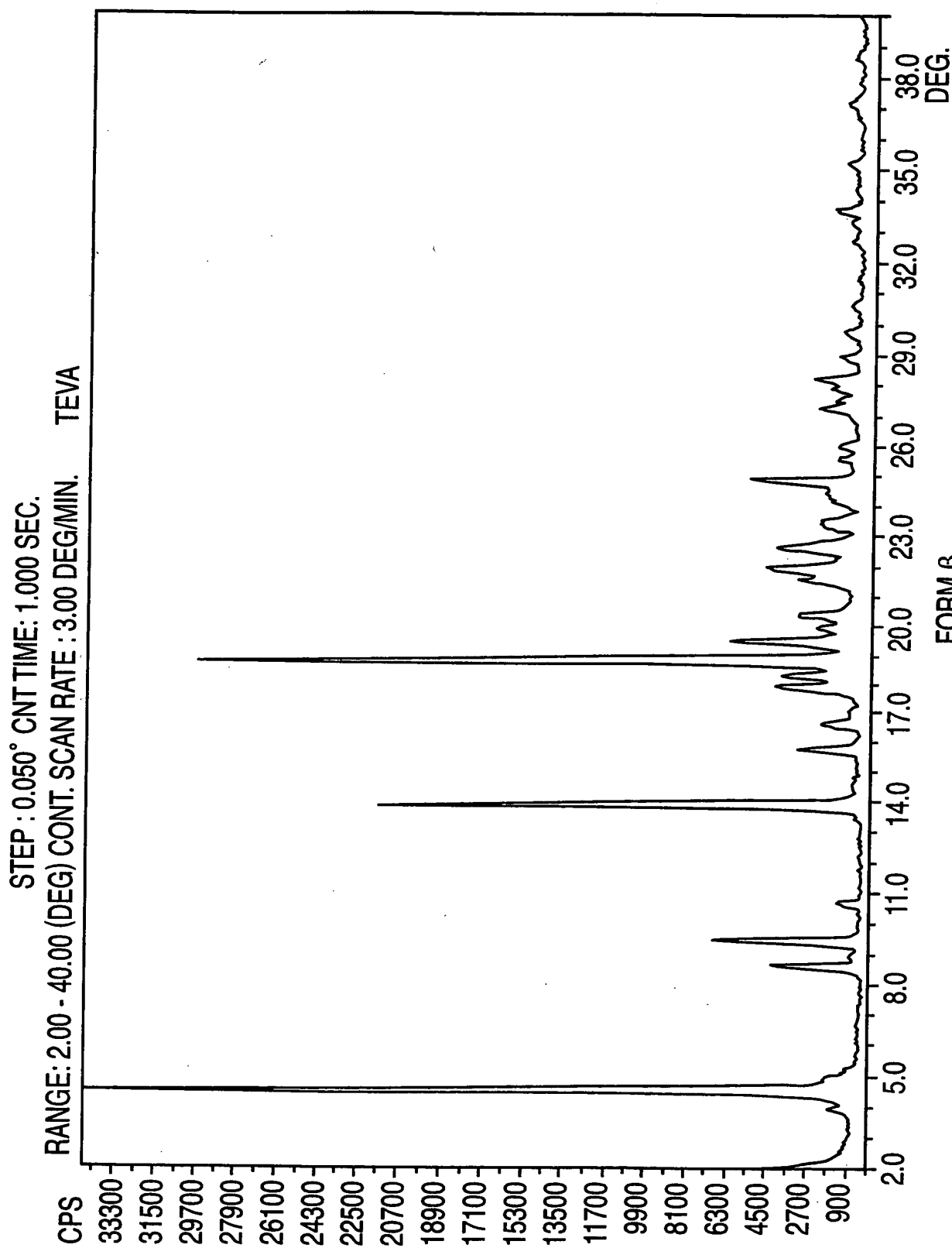


FIG. 22

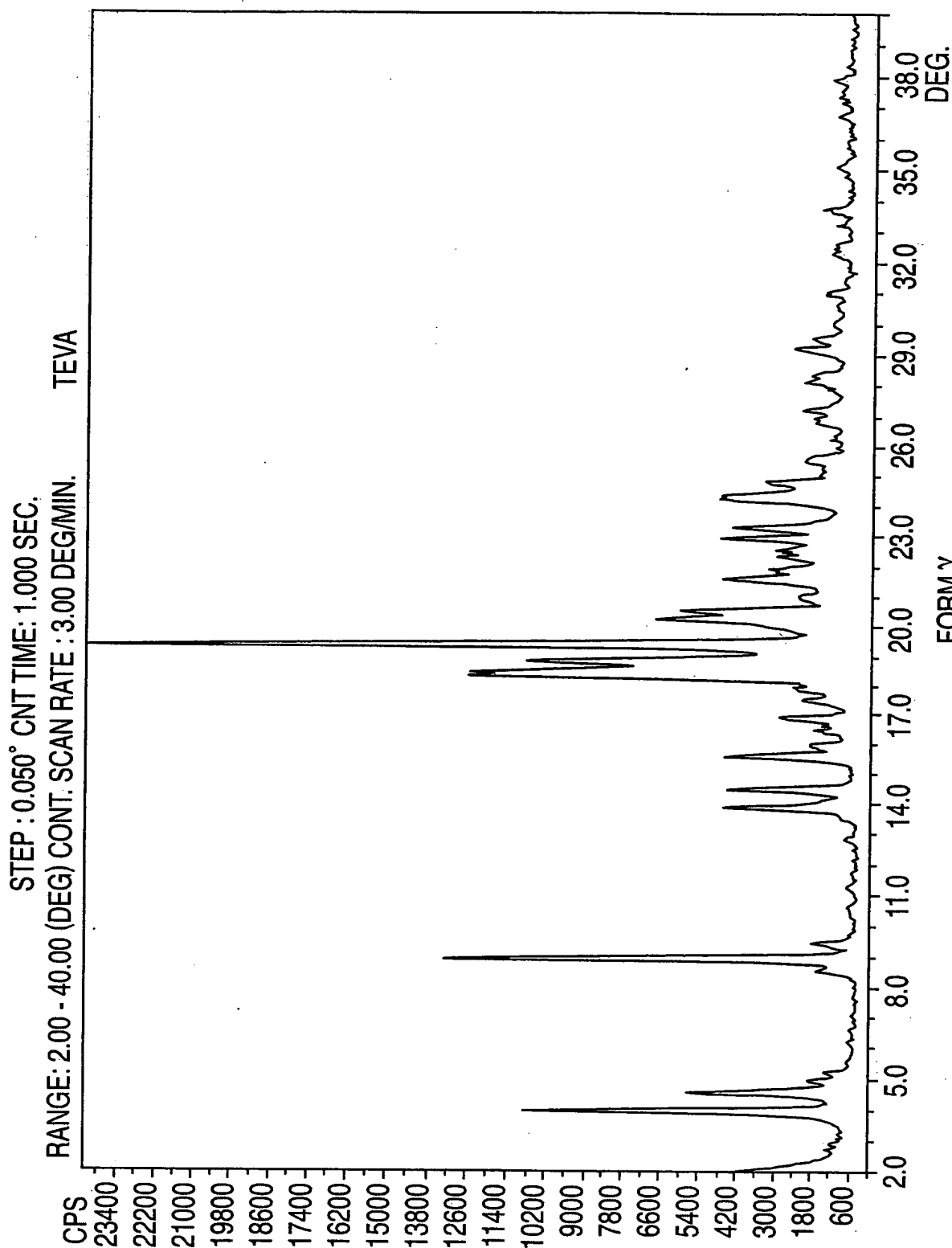


FIG. 23

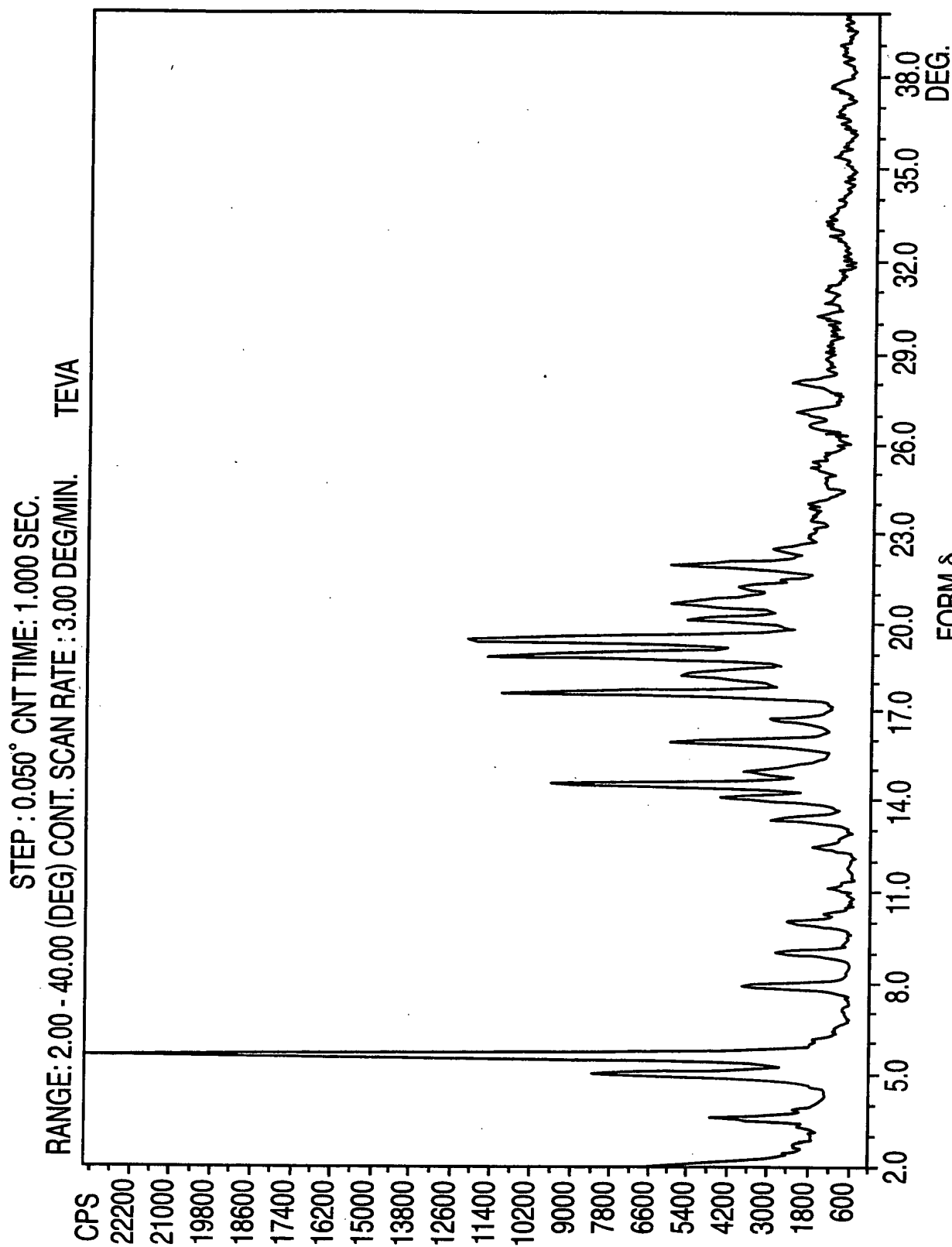


FIG. 24

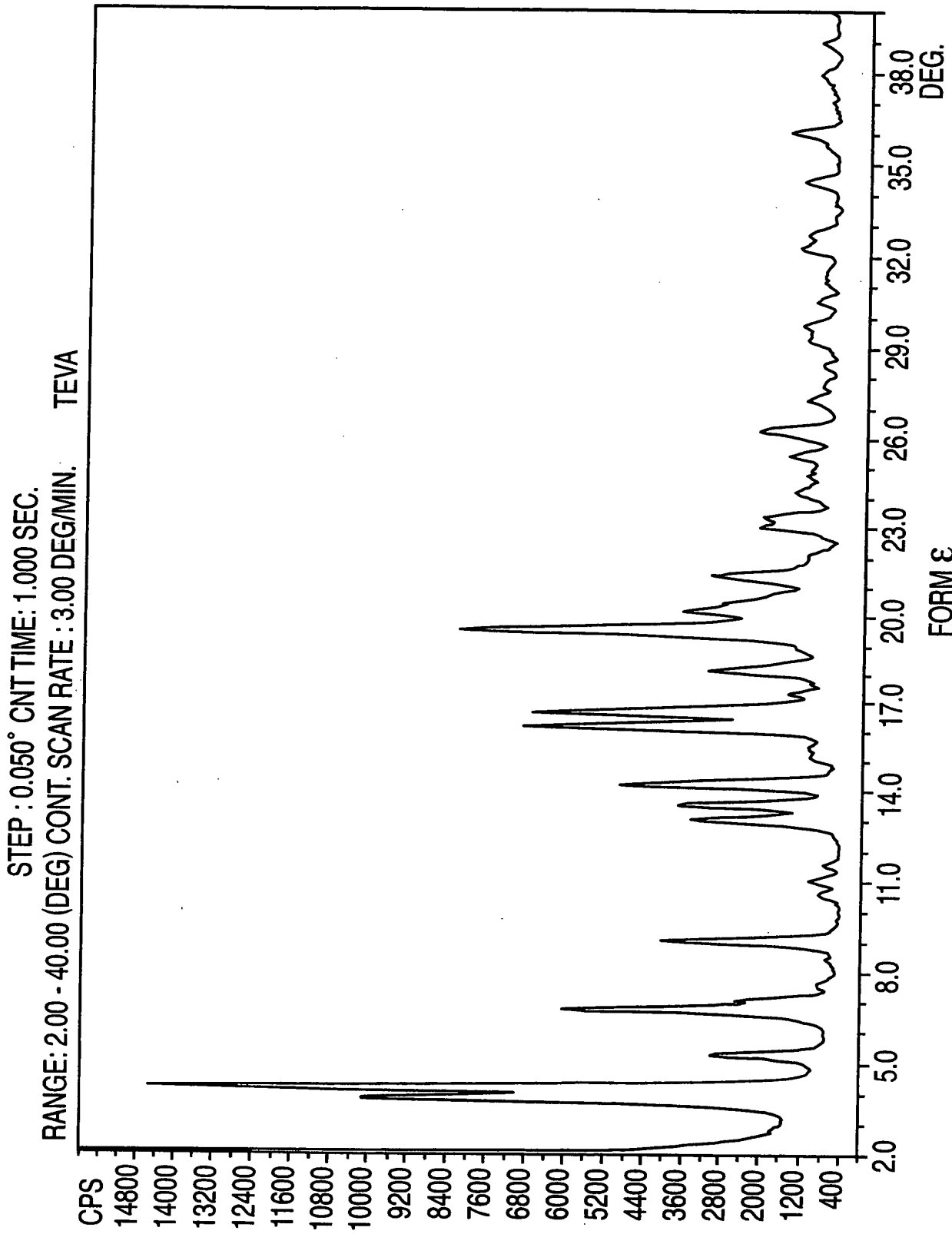


FIG. 25

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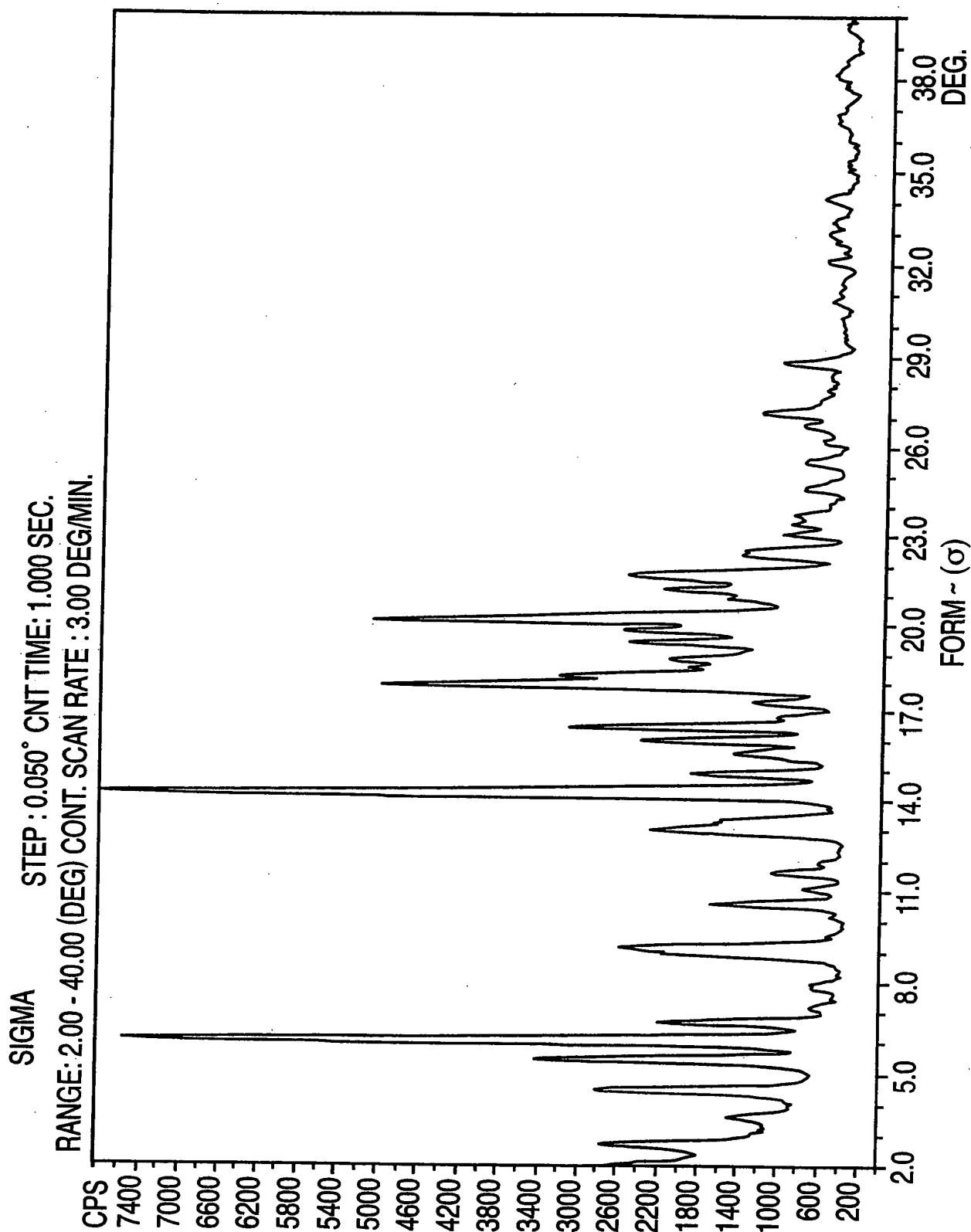


FIG. 26

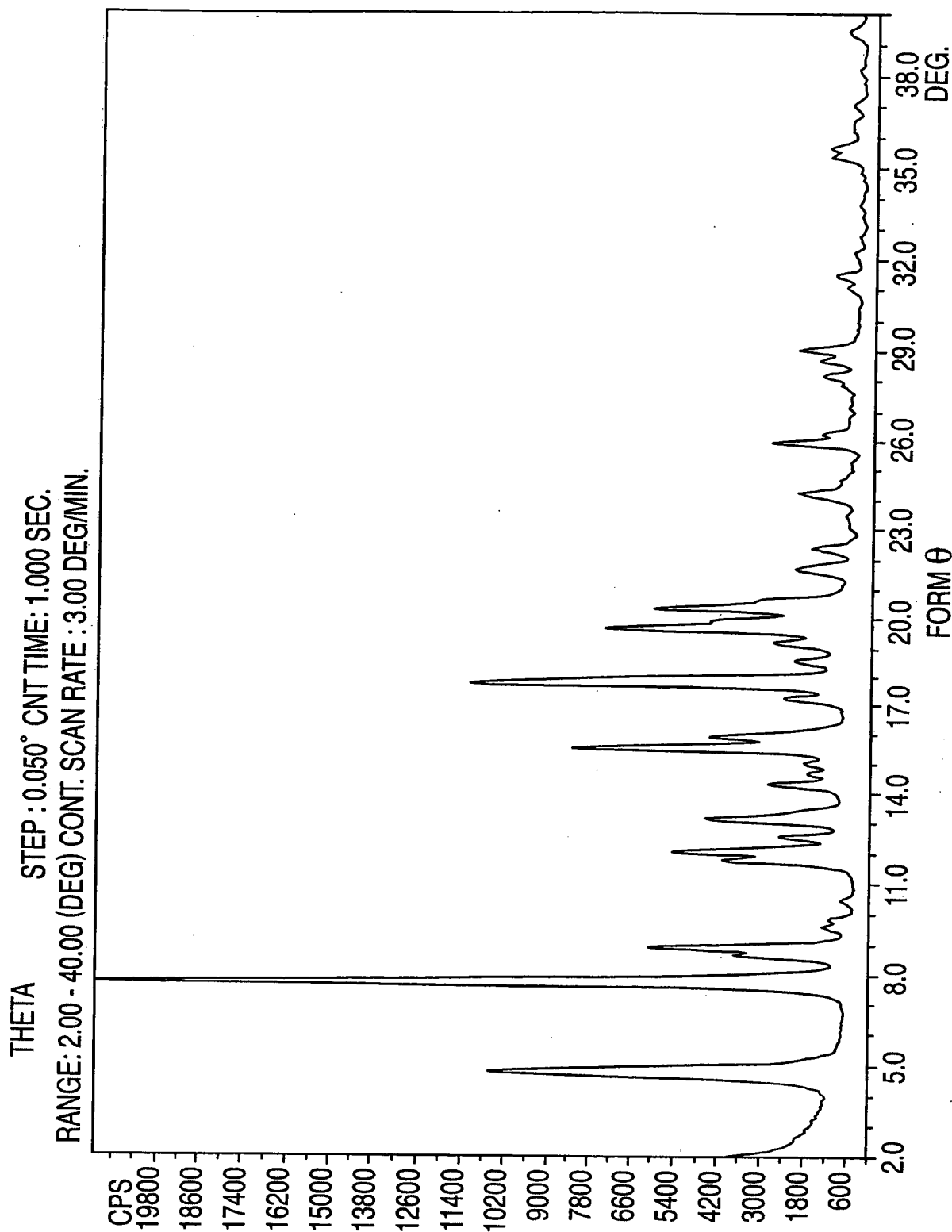
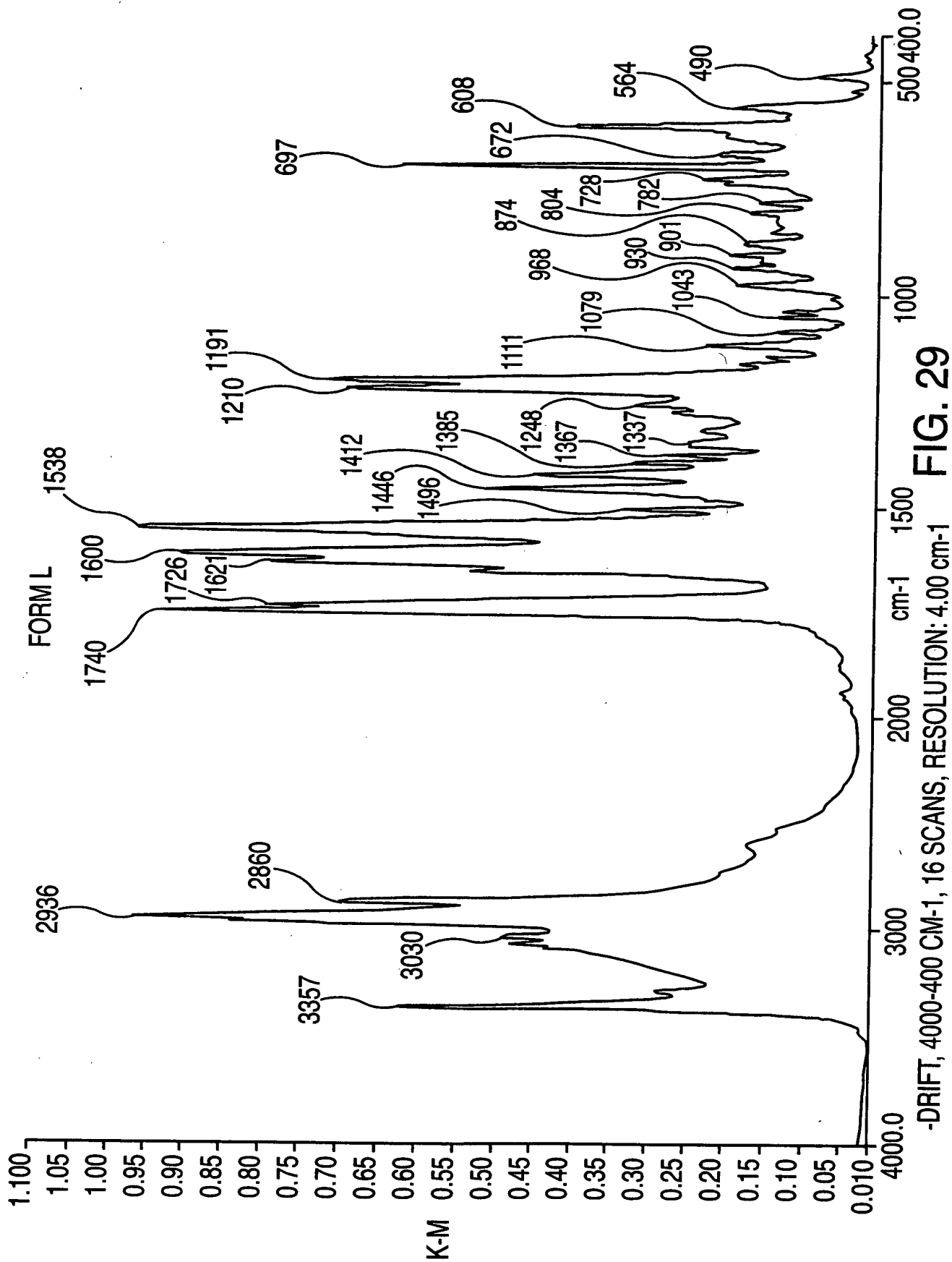
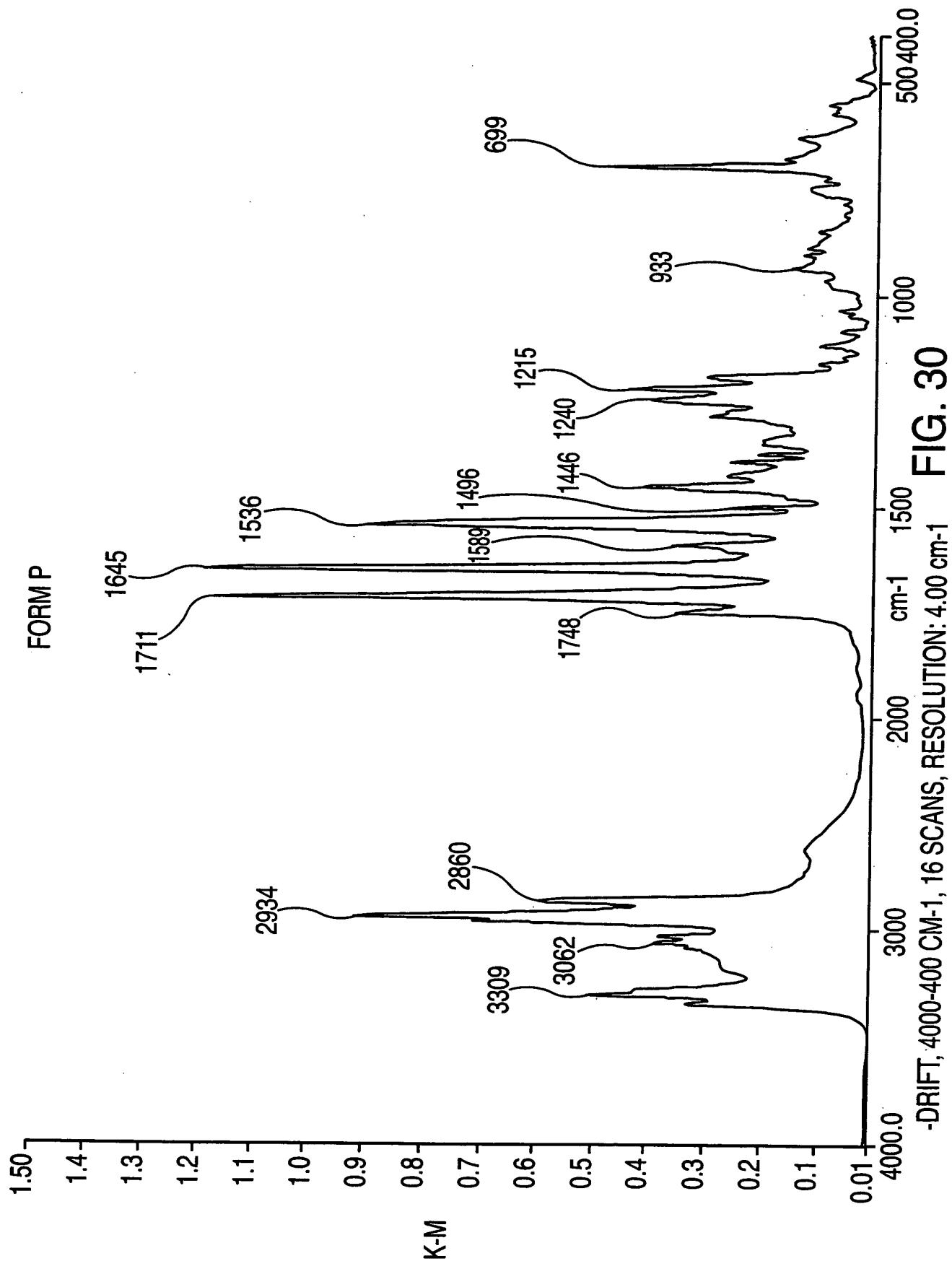
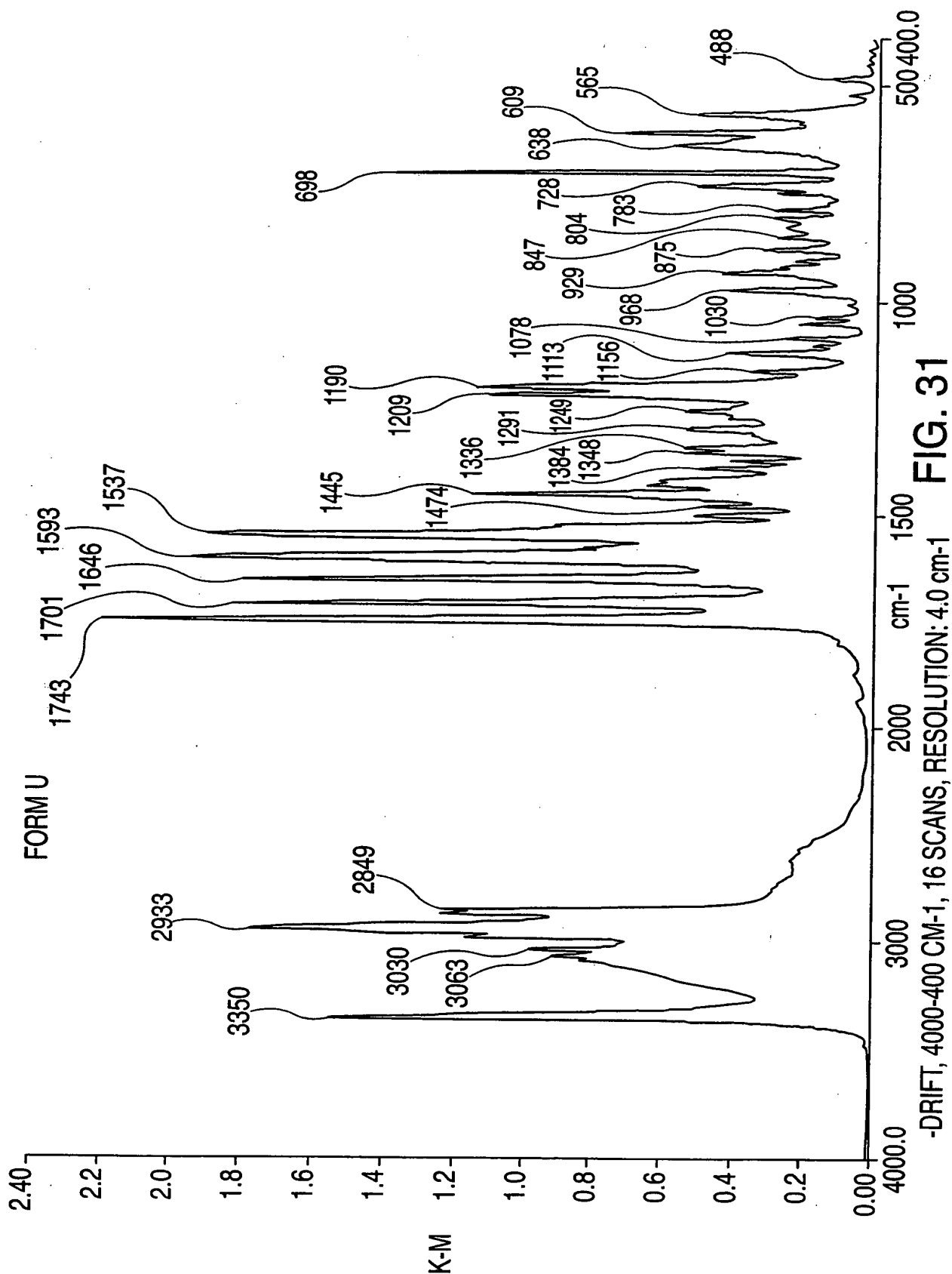
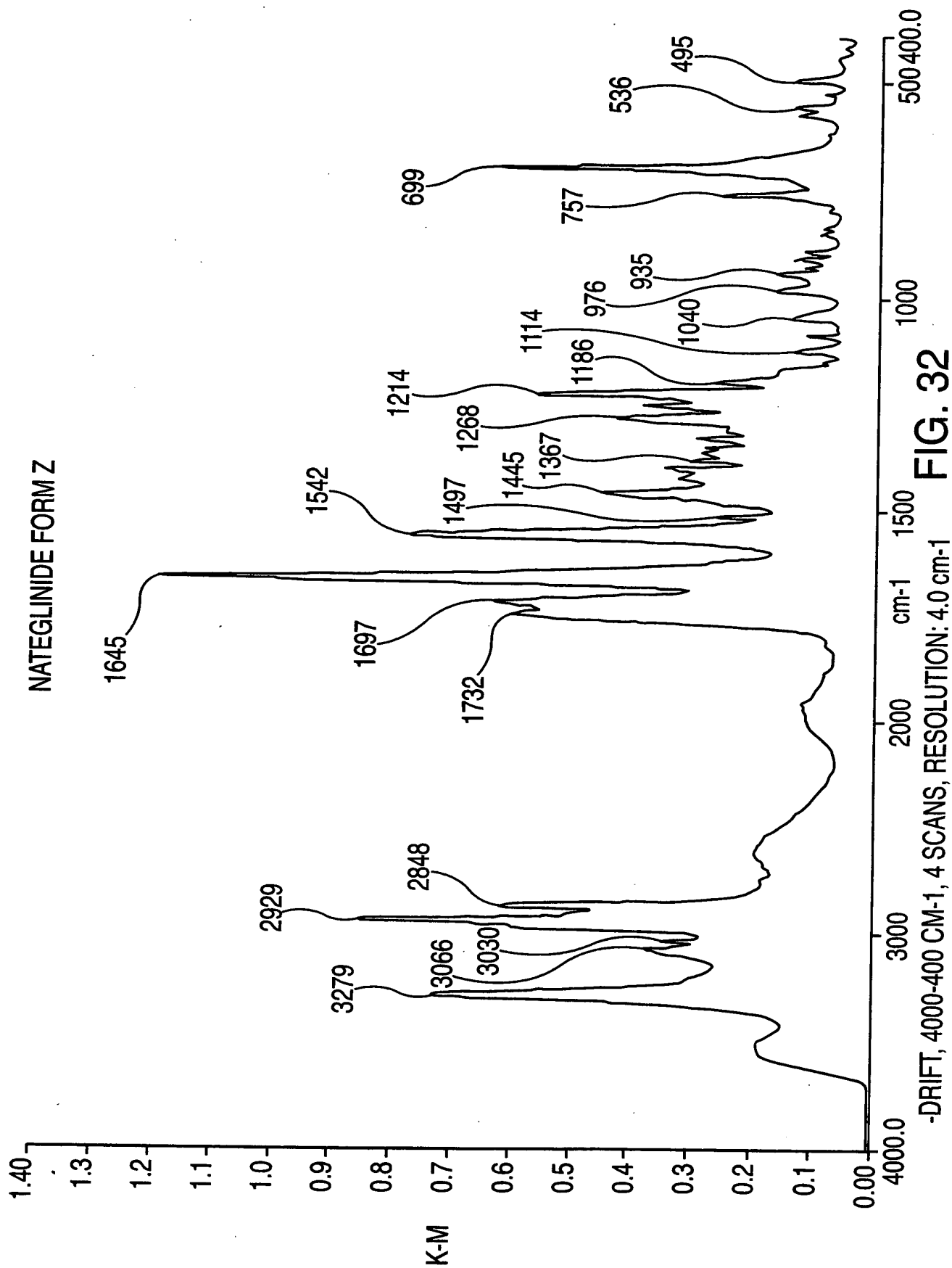


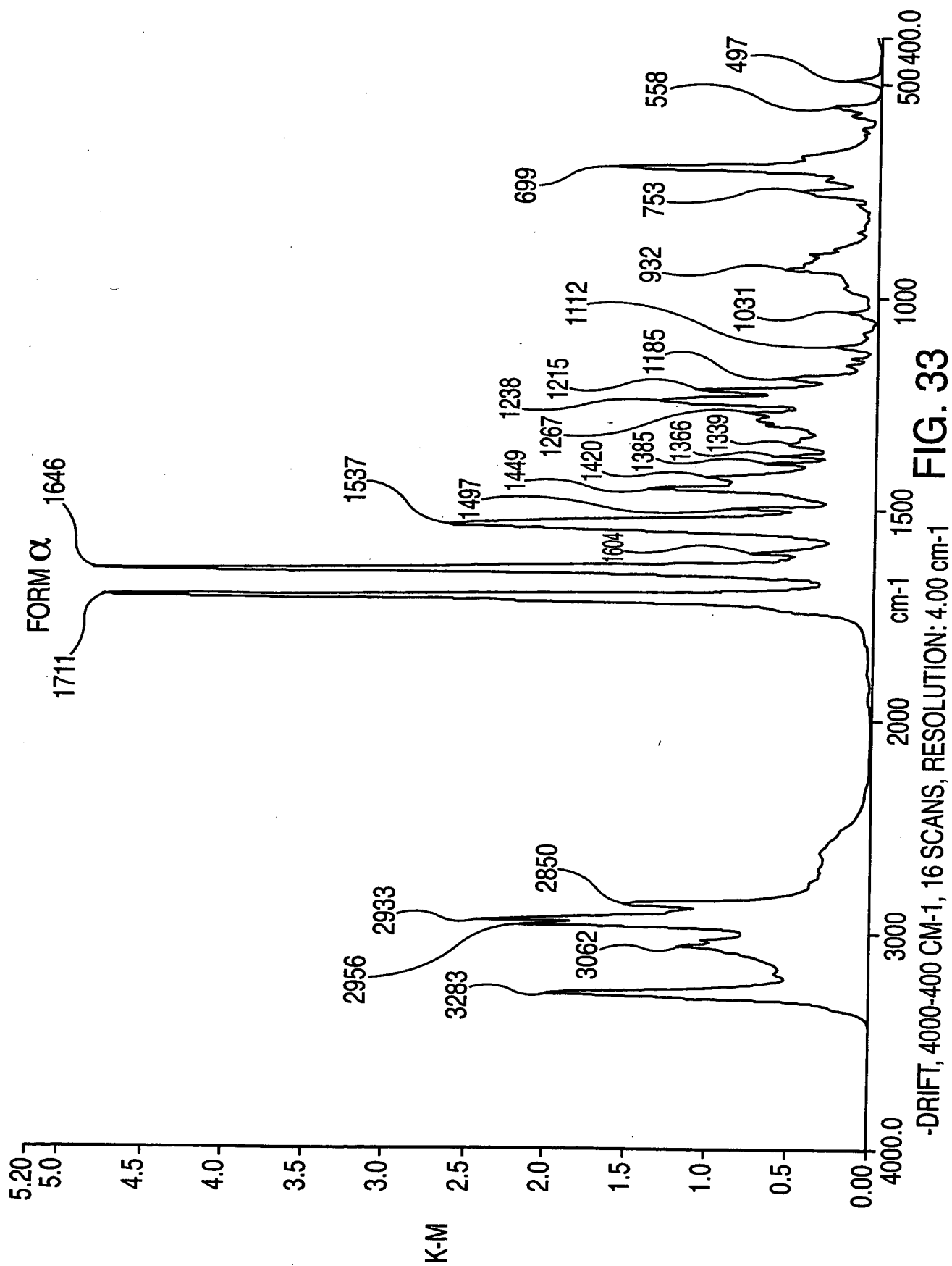
FIG. 27

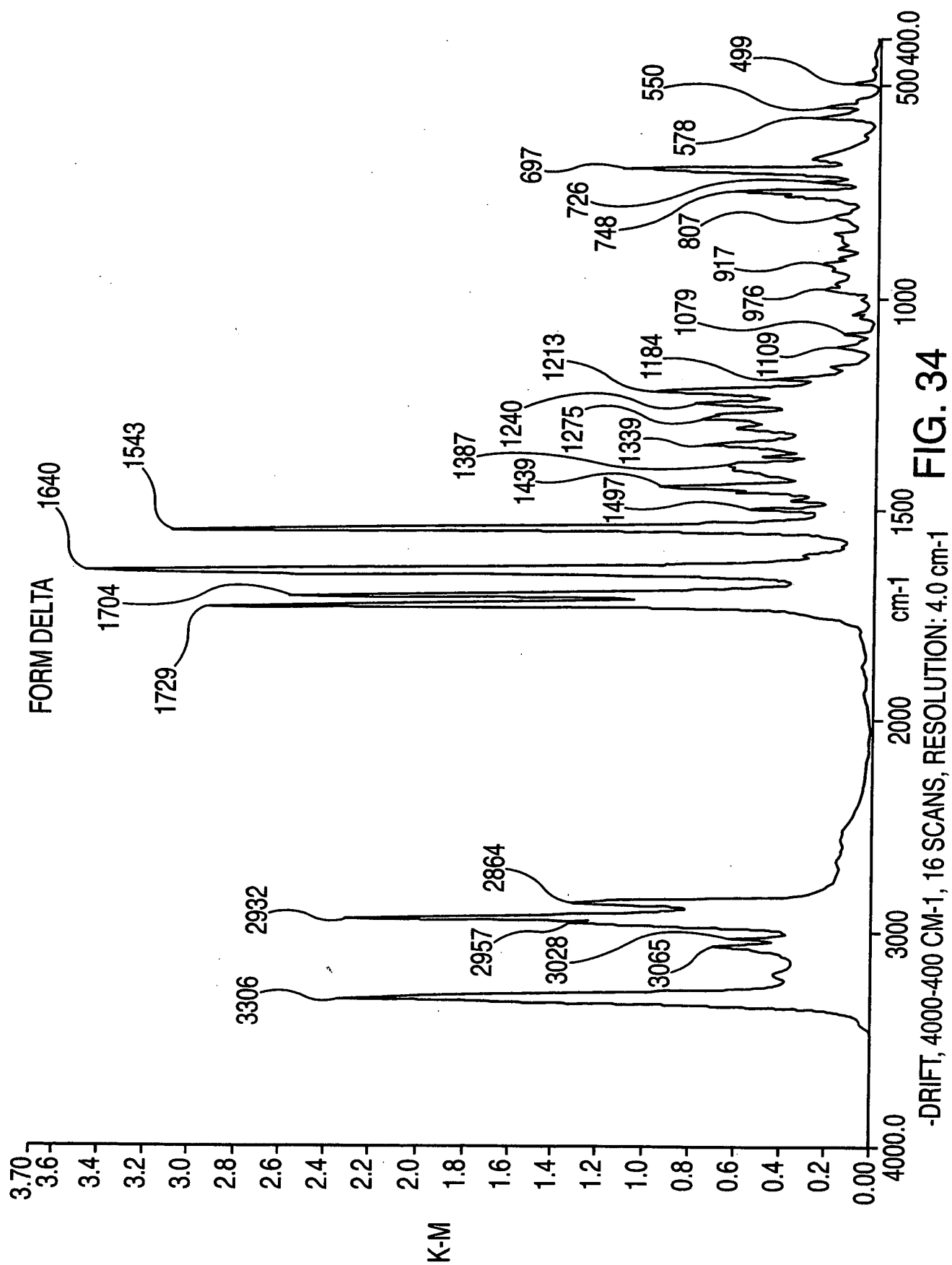












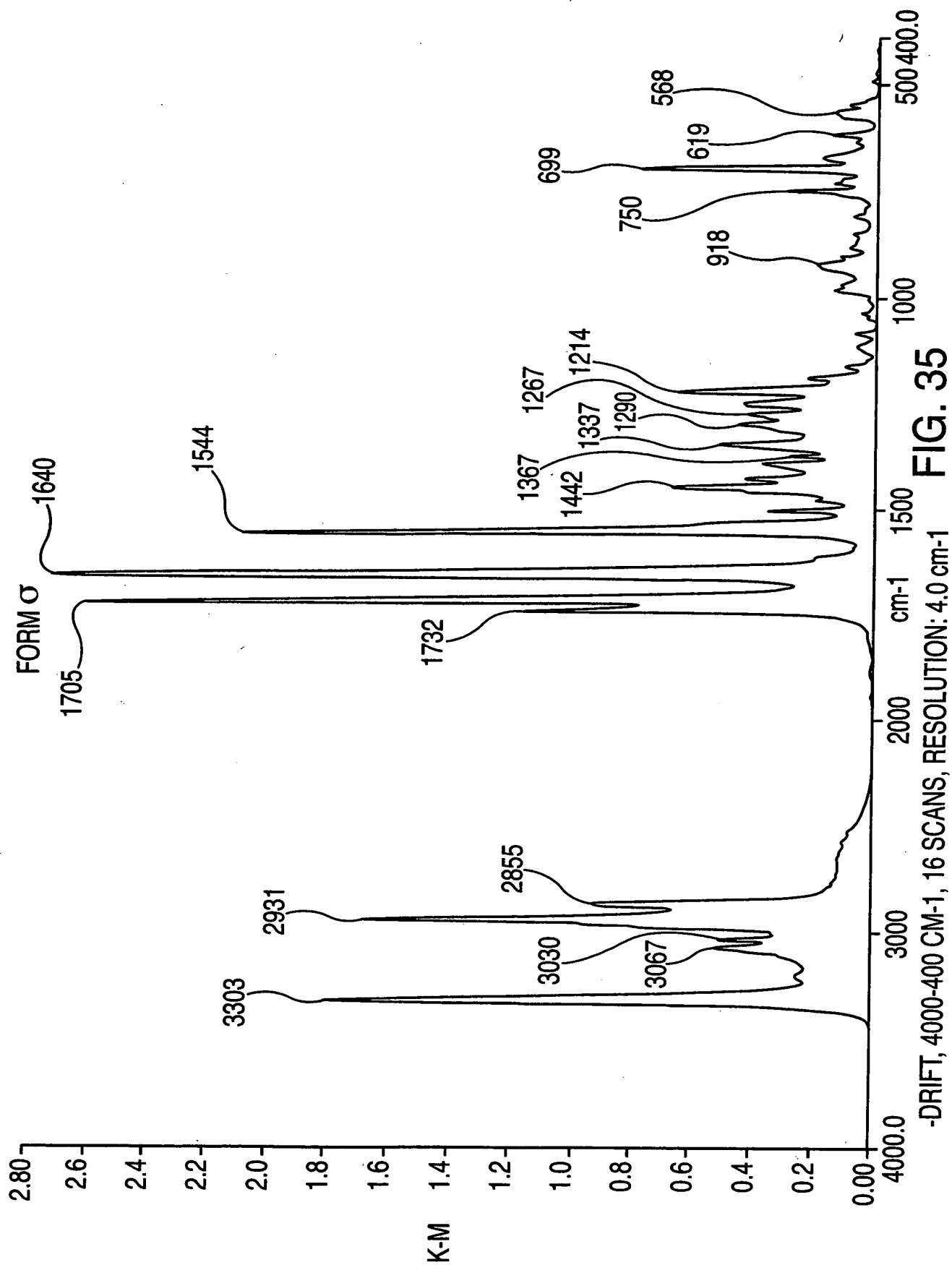
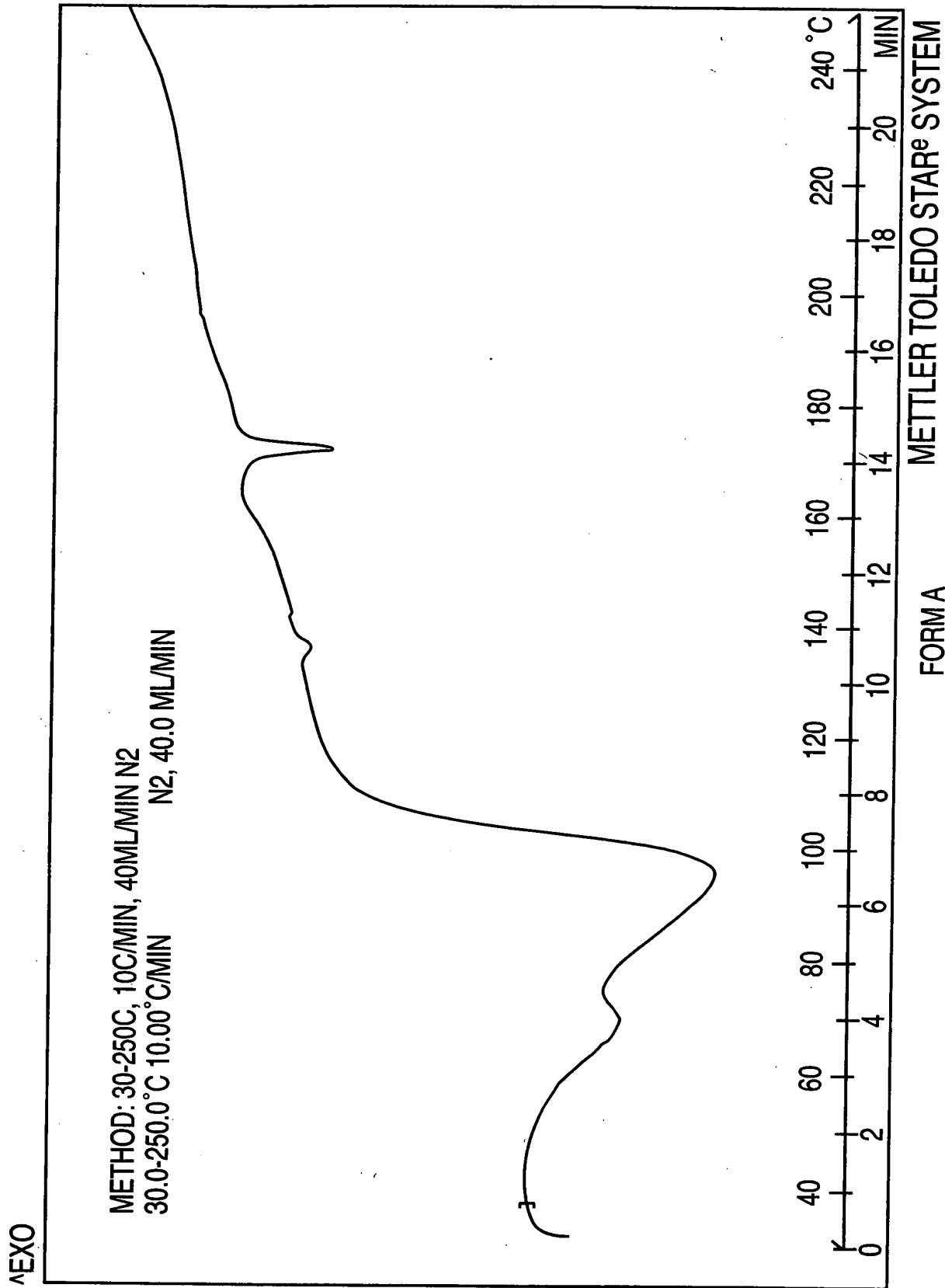
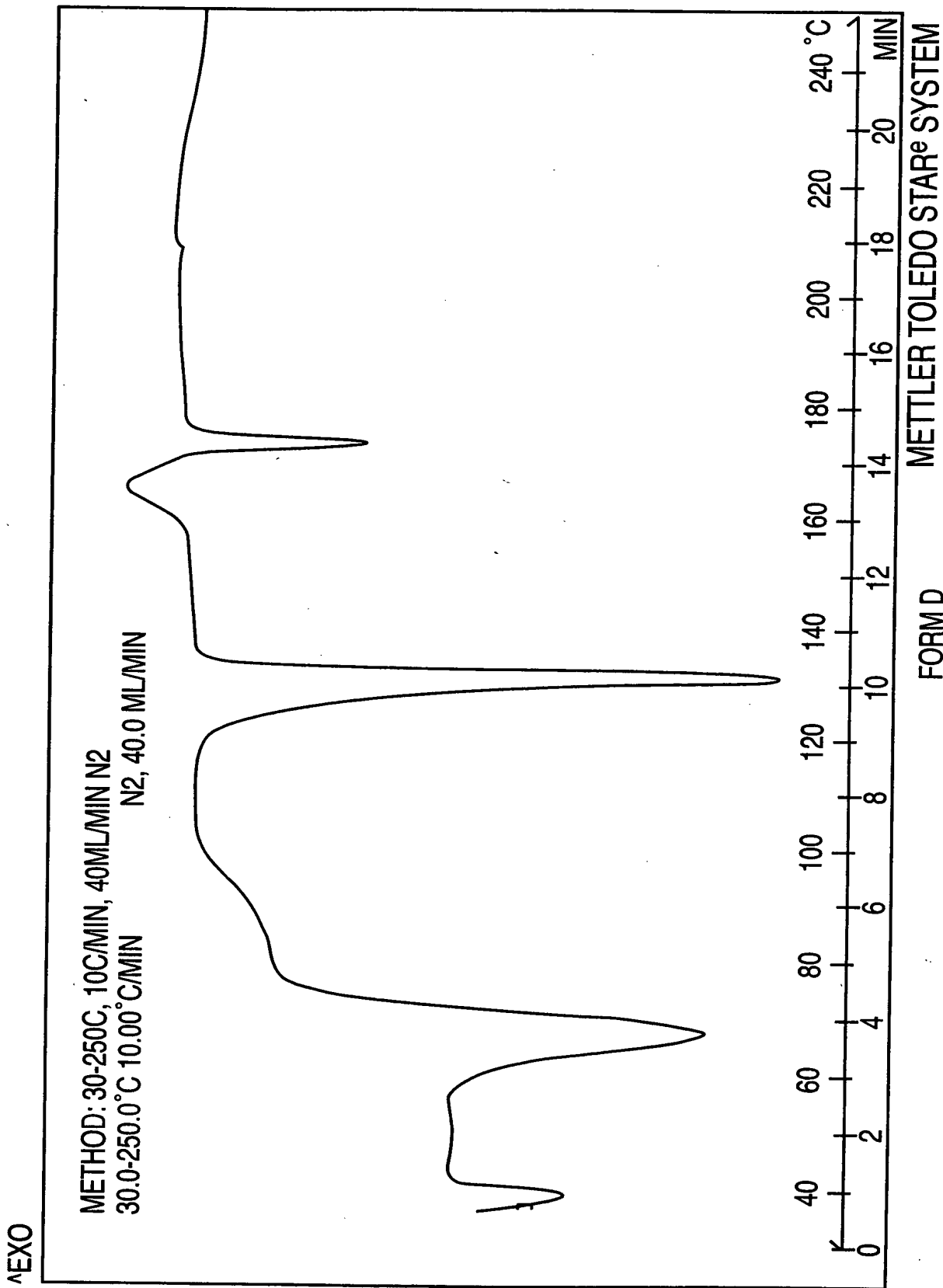


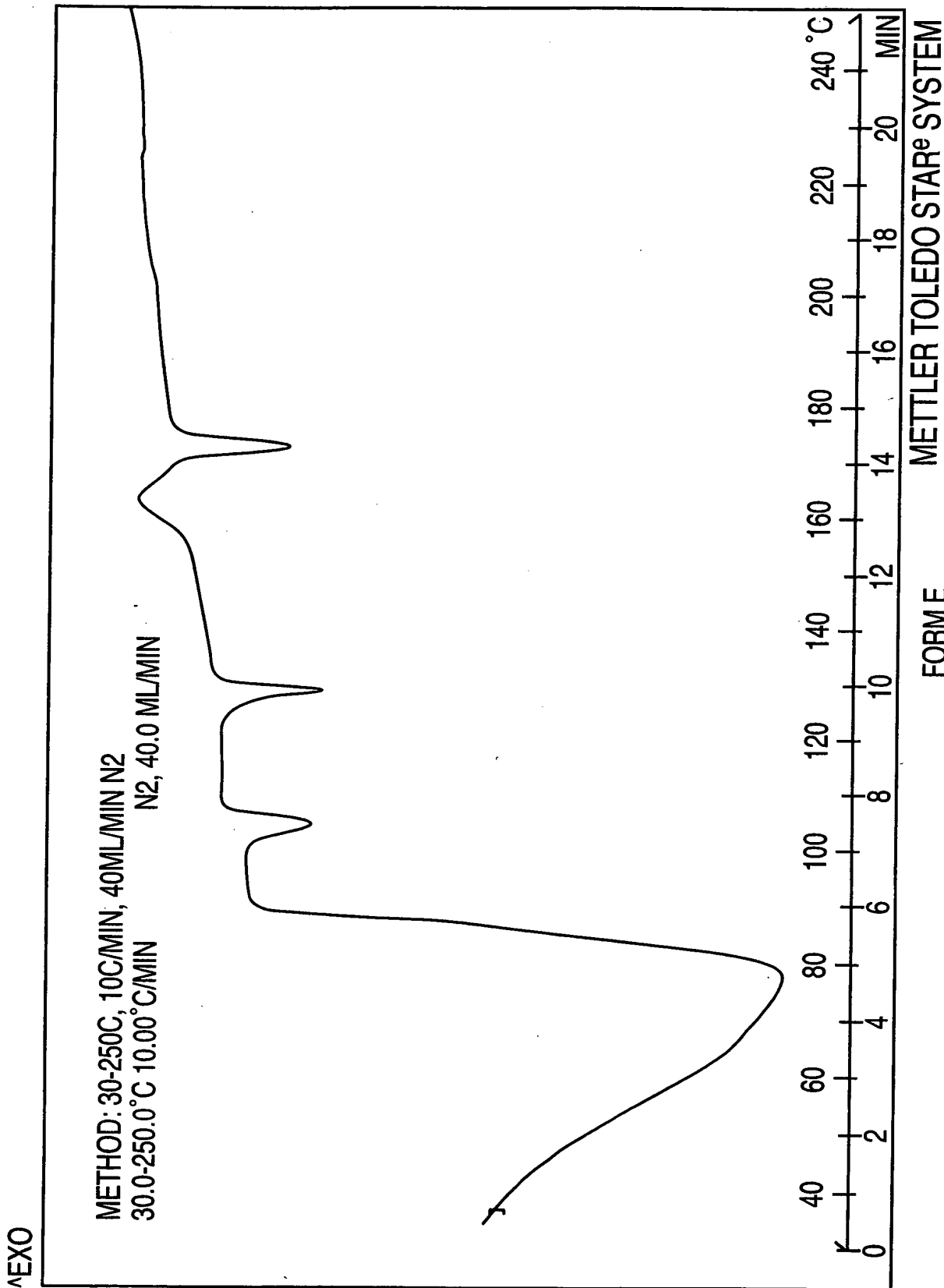
FIG. 35





FORM D

FIG. 37



FORM E
FIG. 38

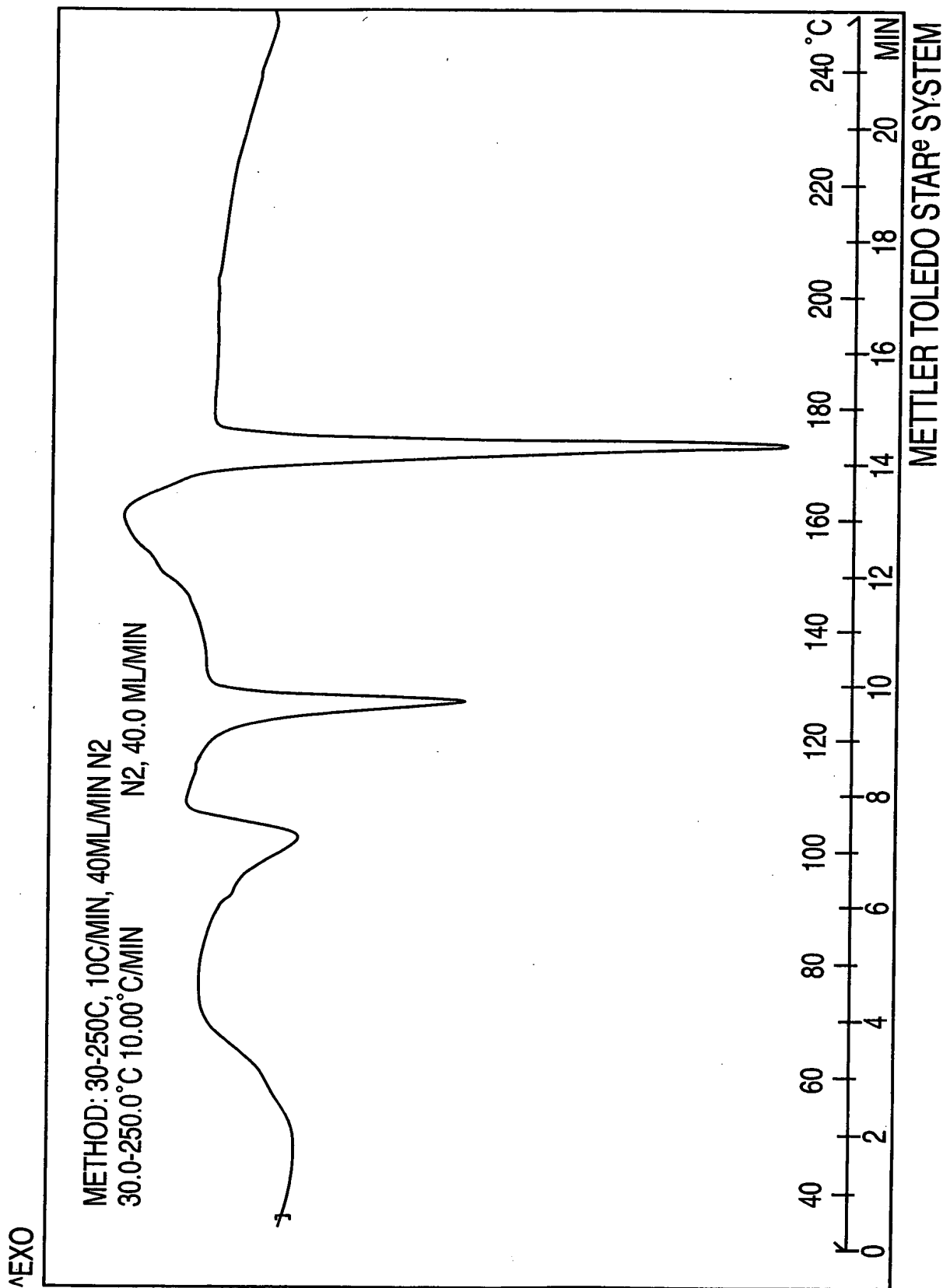


FIG. 39

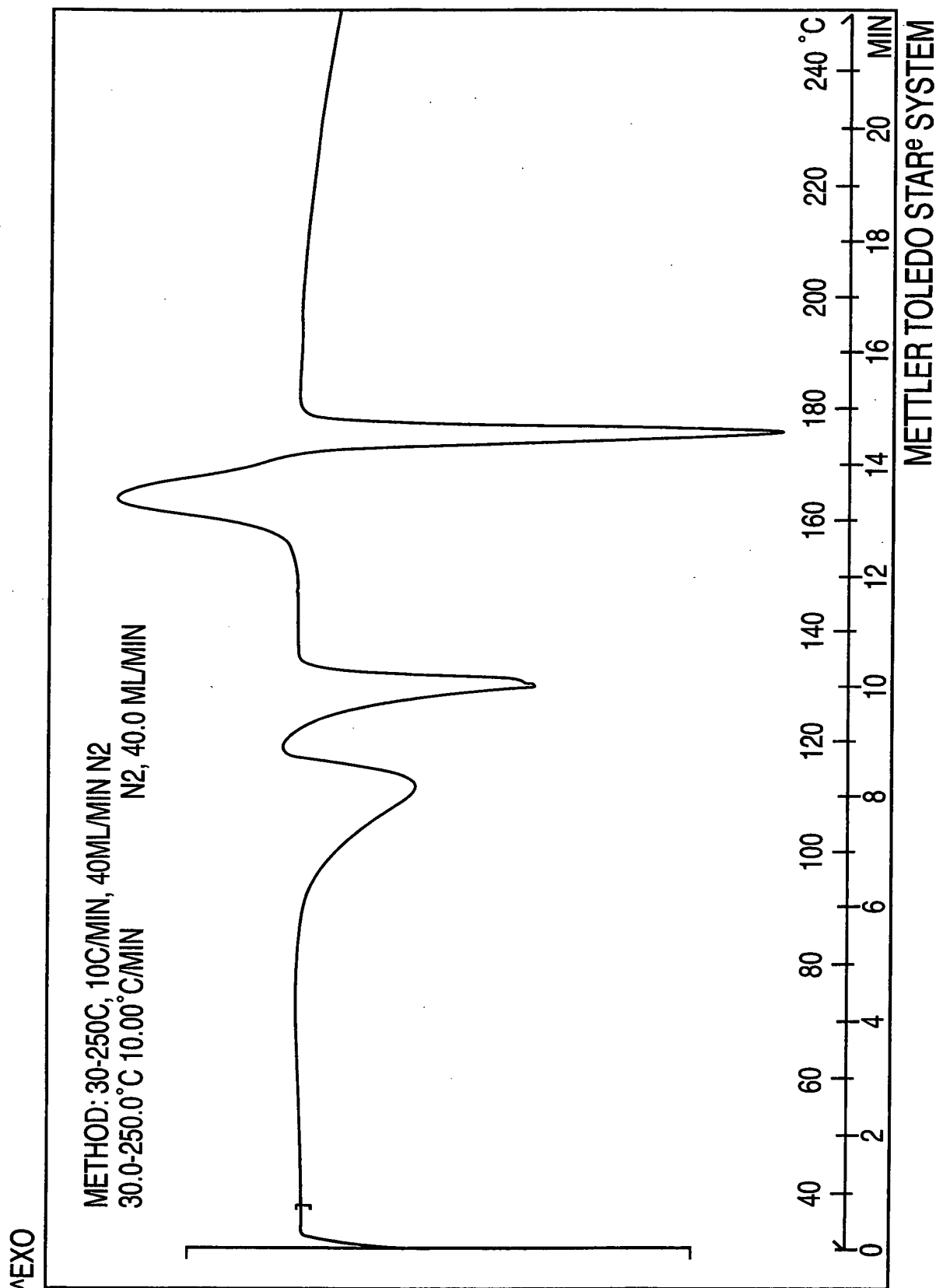


FIG. 40

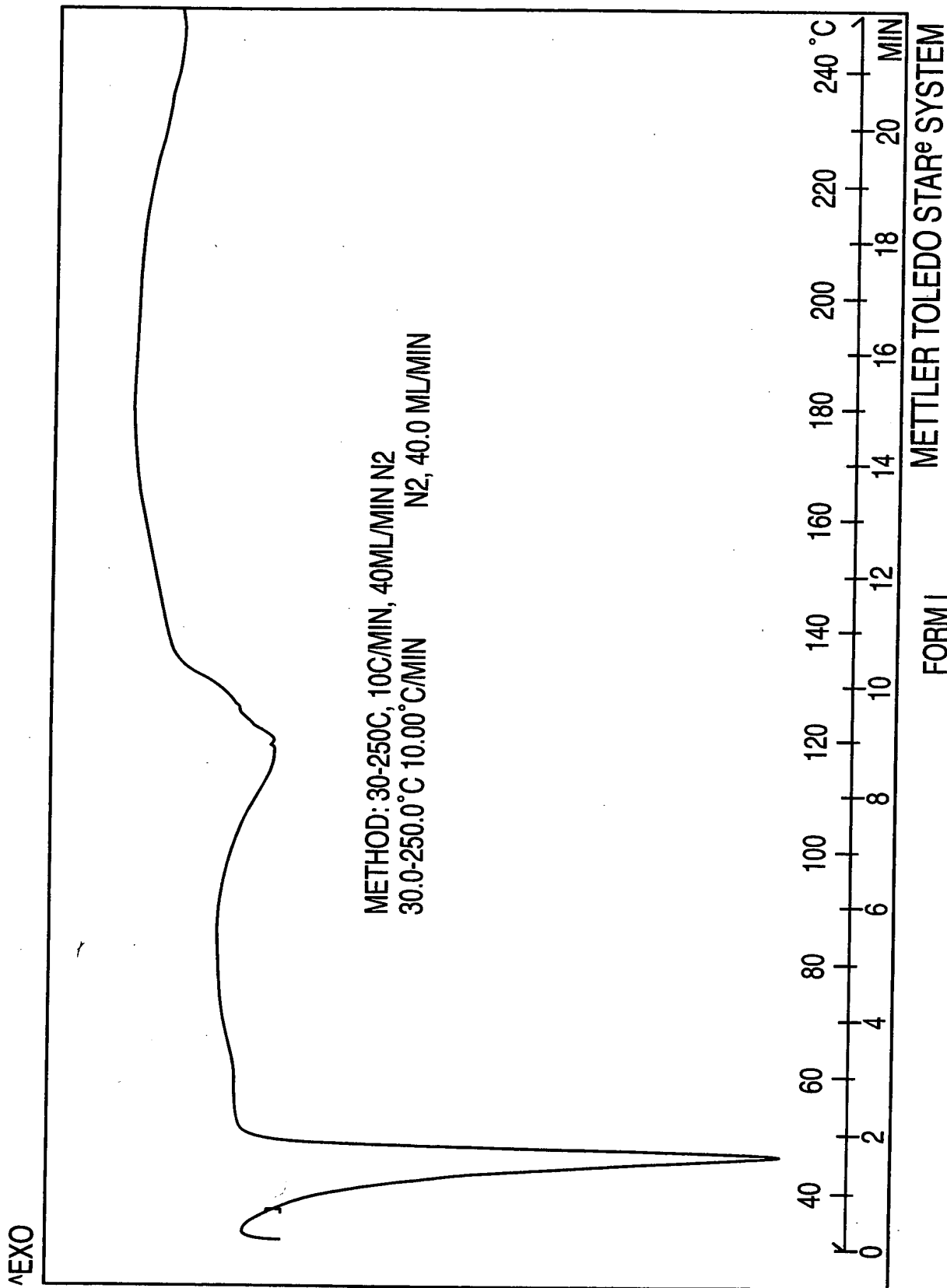


FIG. 41

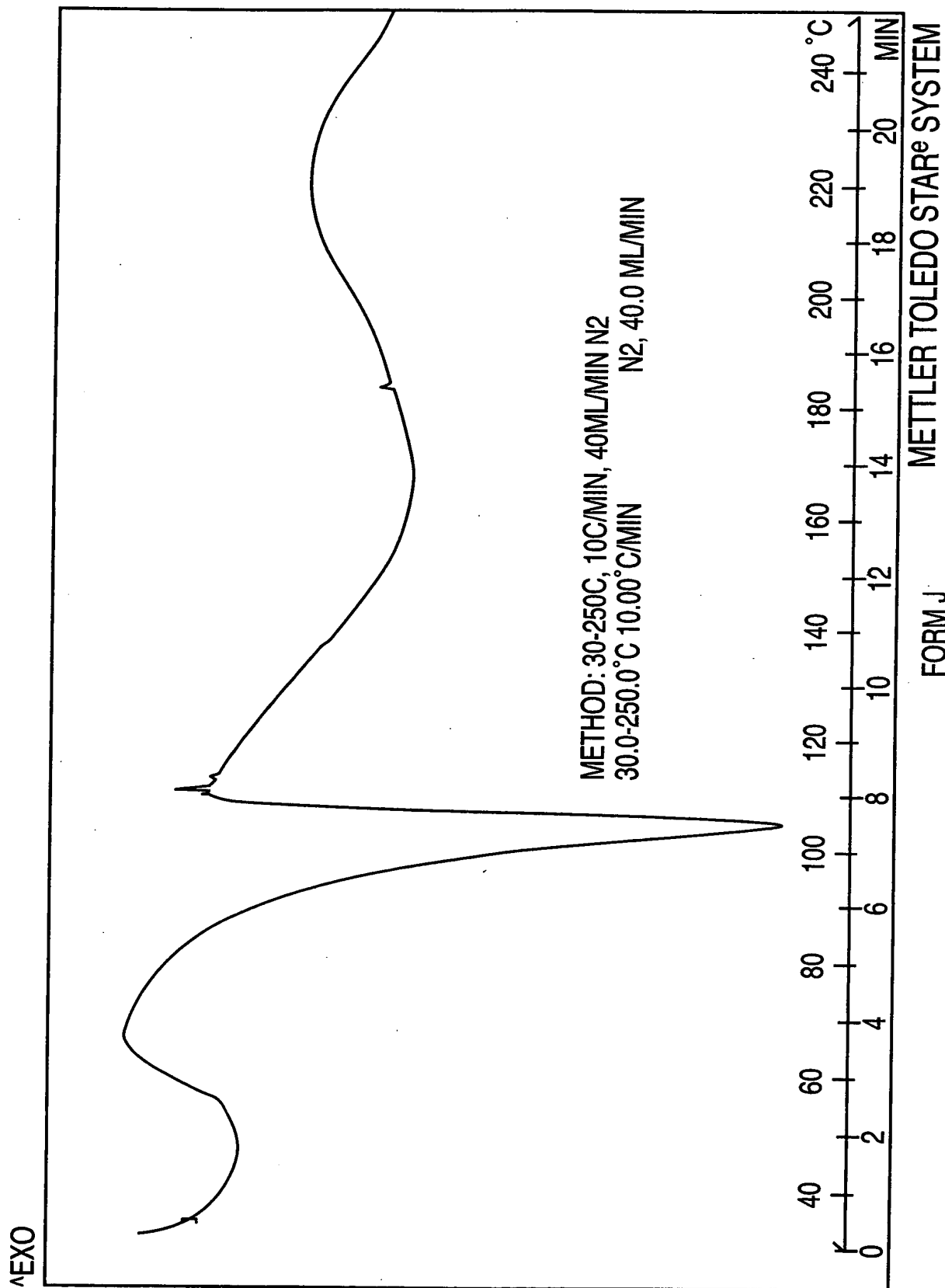


FIG. 42

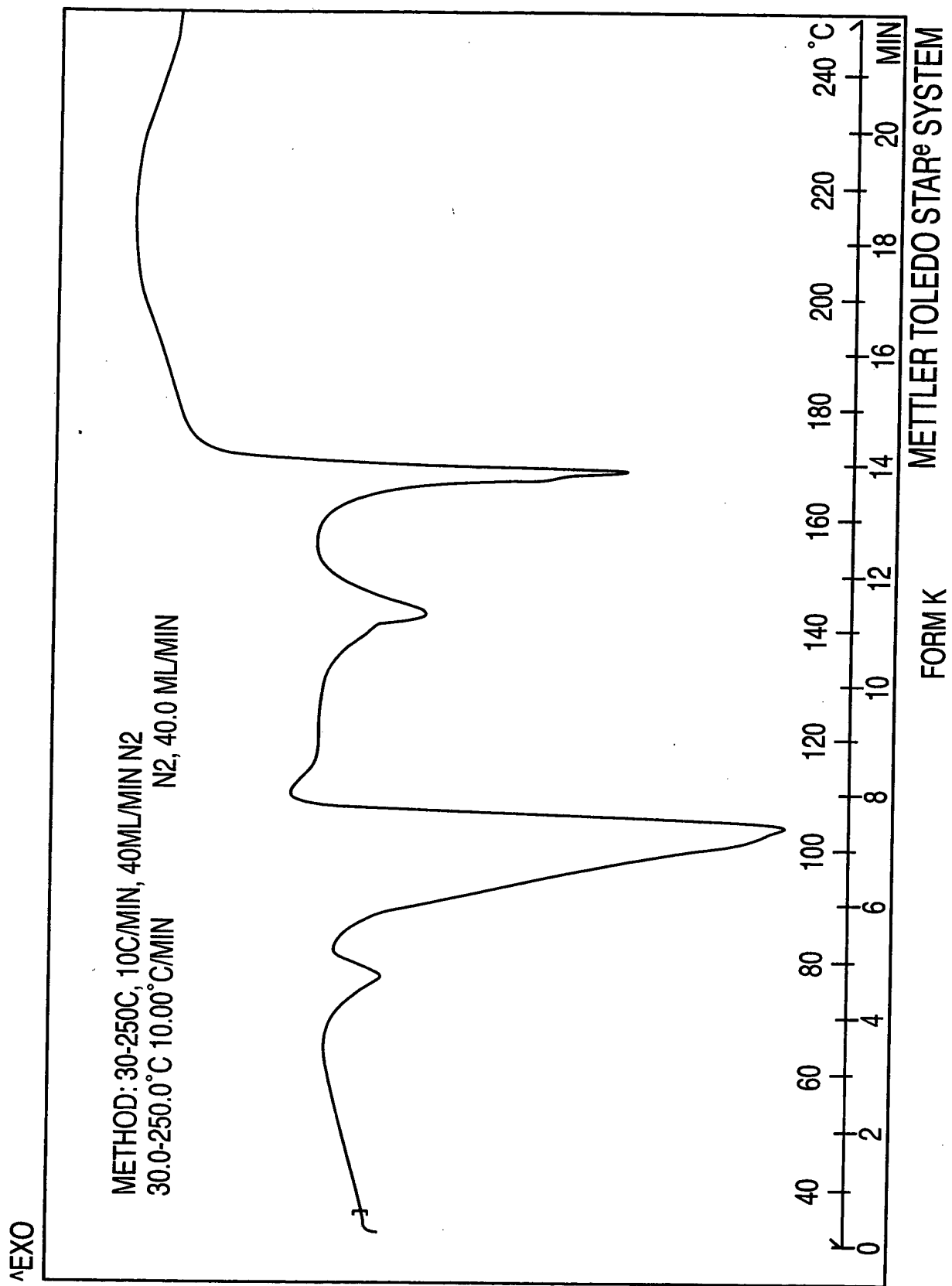


FIG. 43

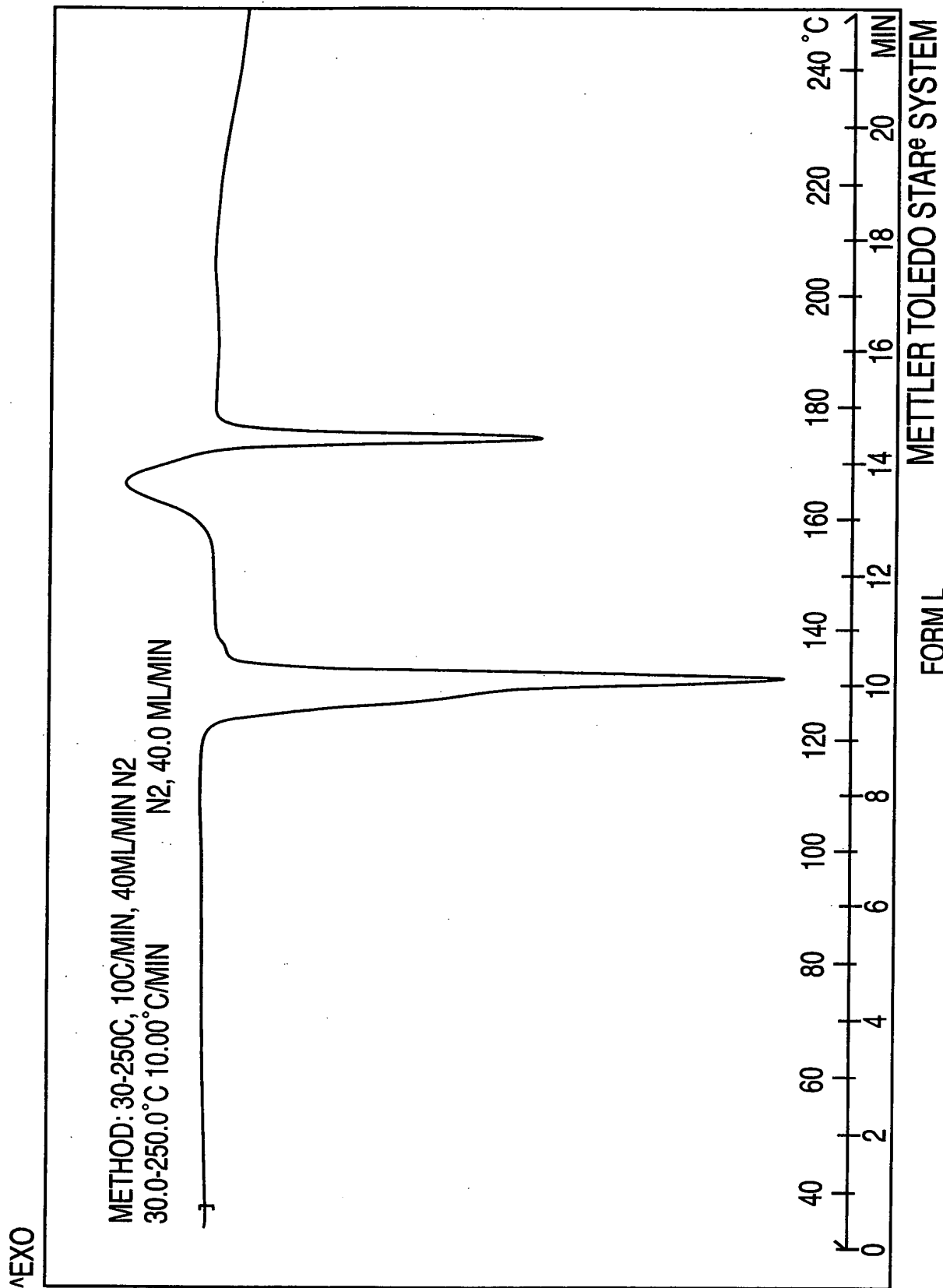
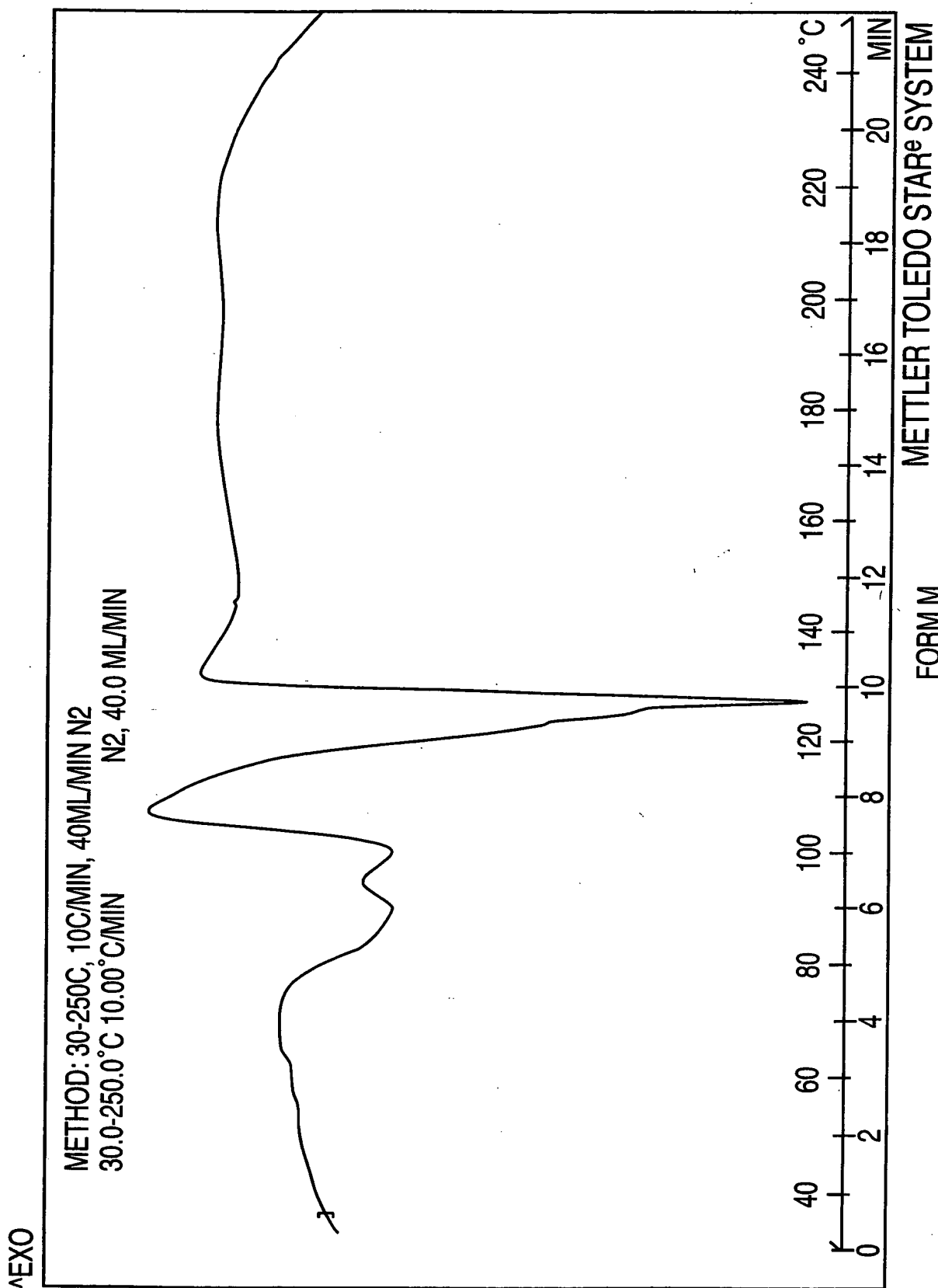


FIG. 44



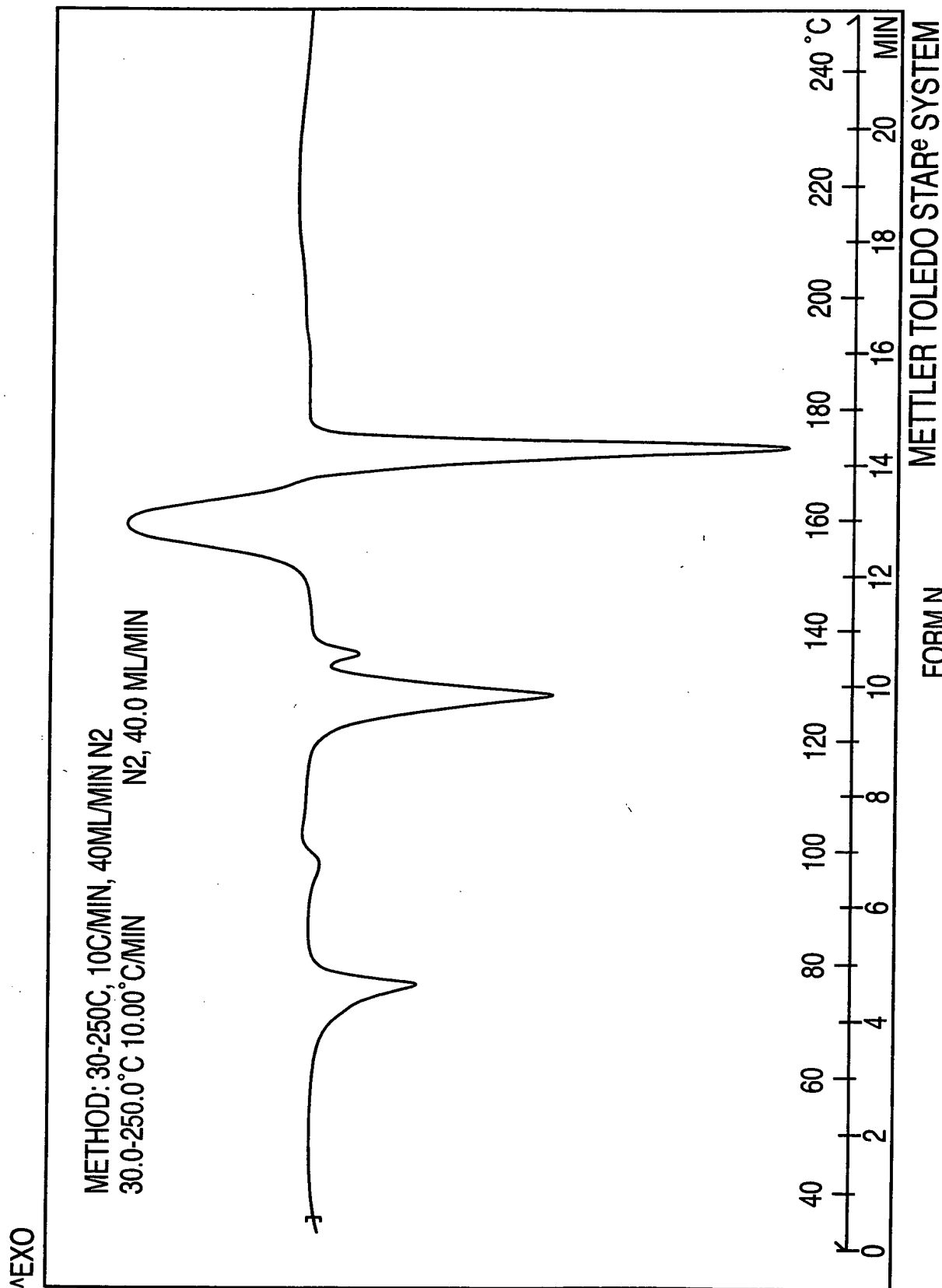


FIG. 46

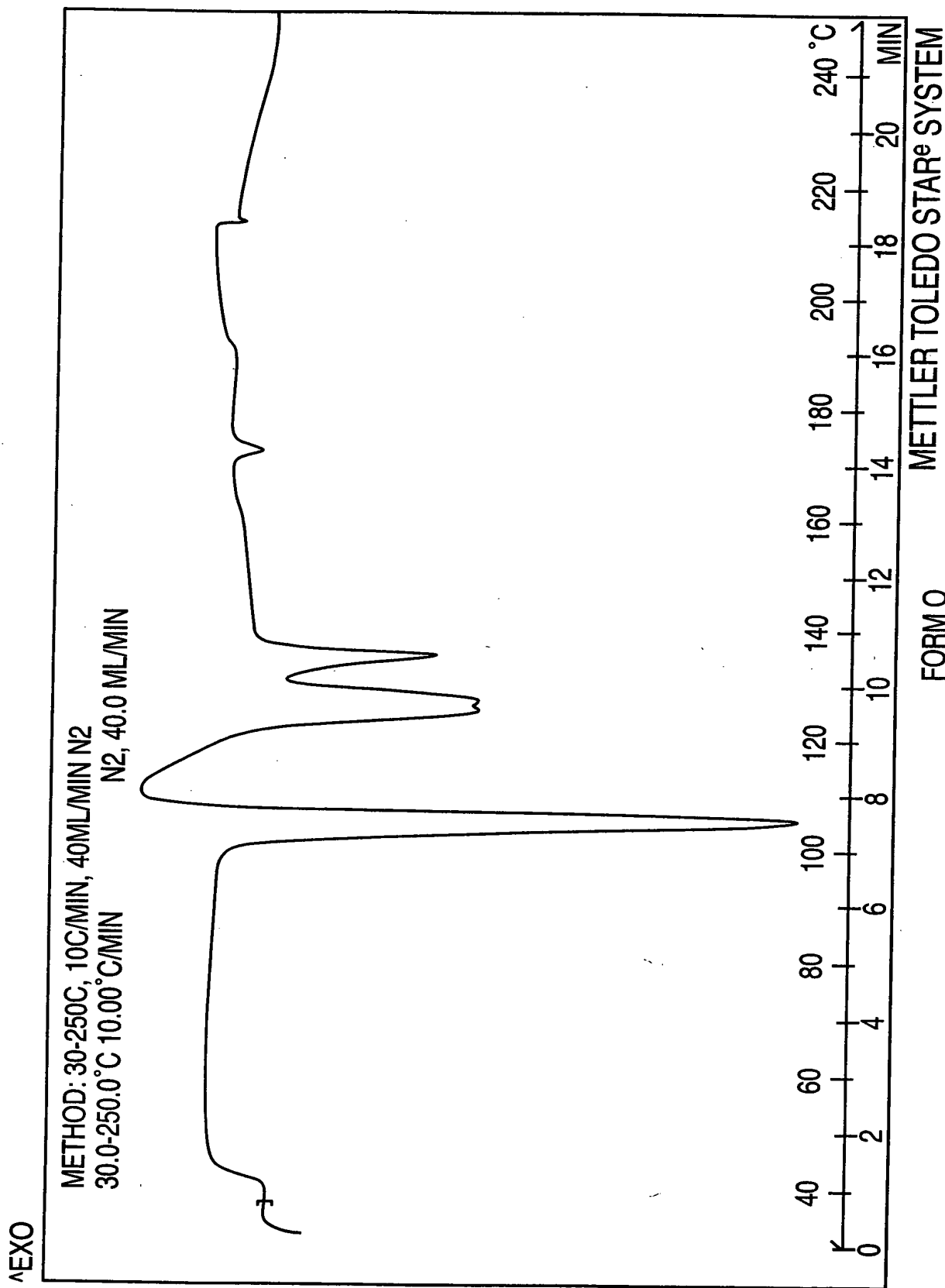
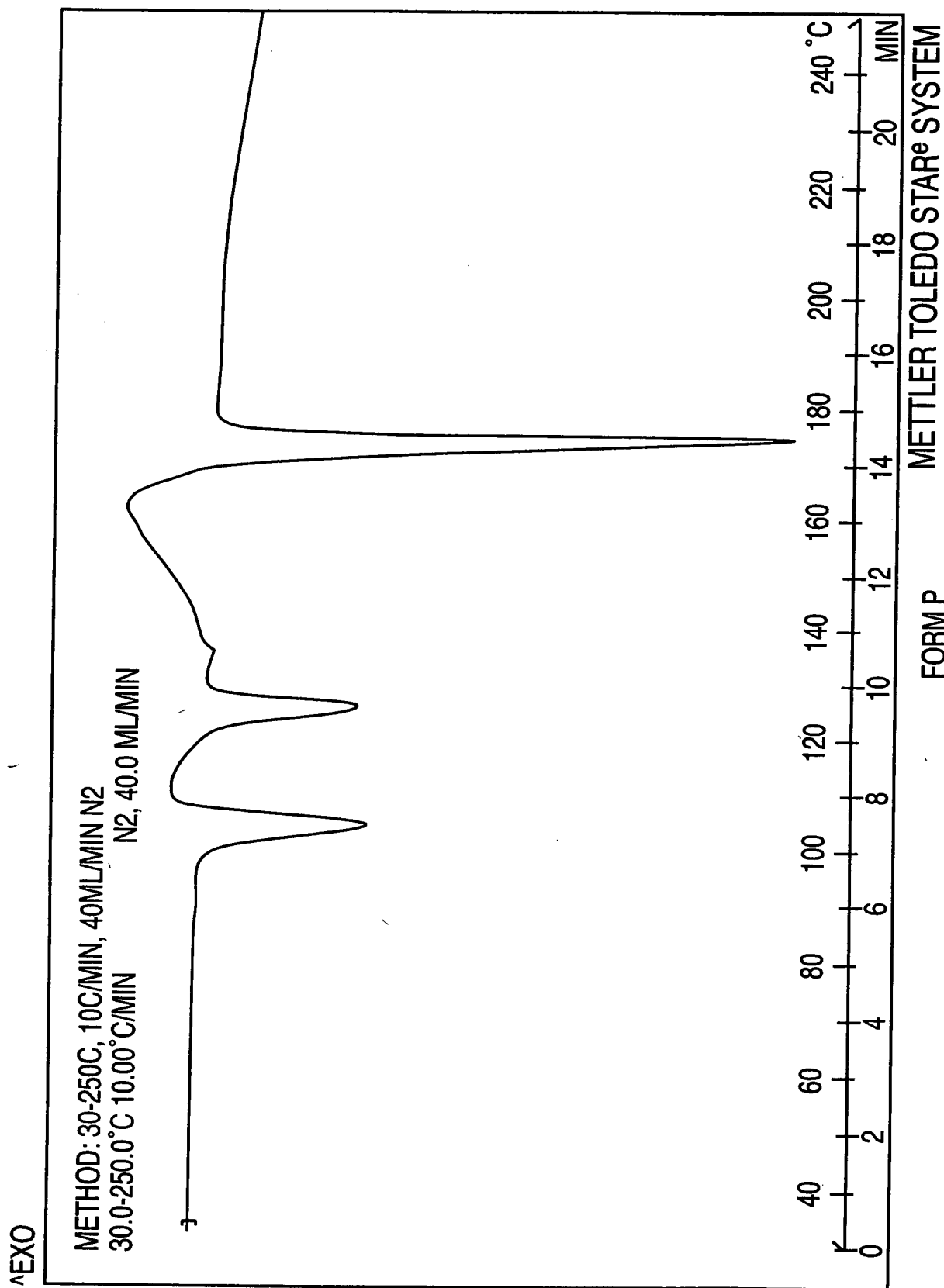


FIG. 47



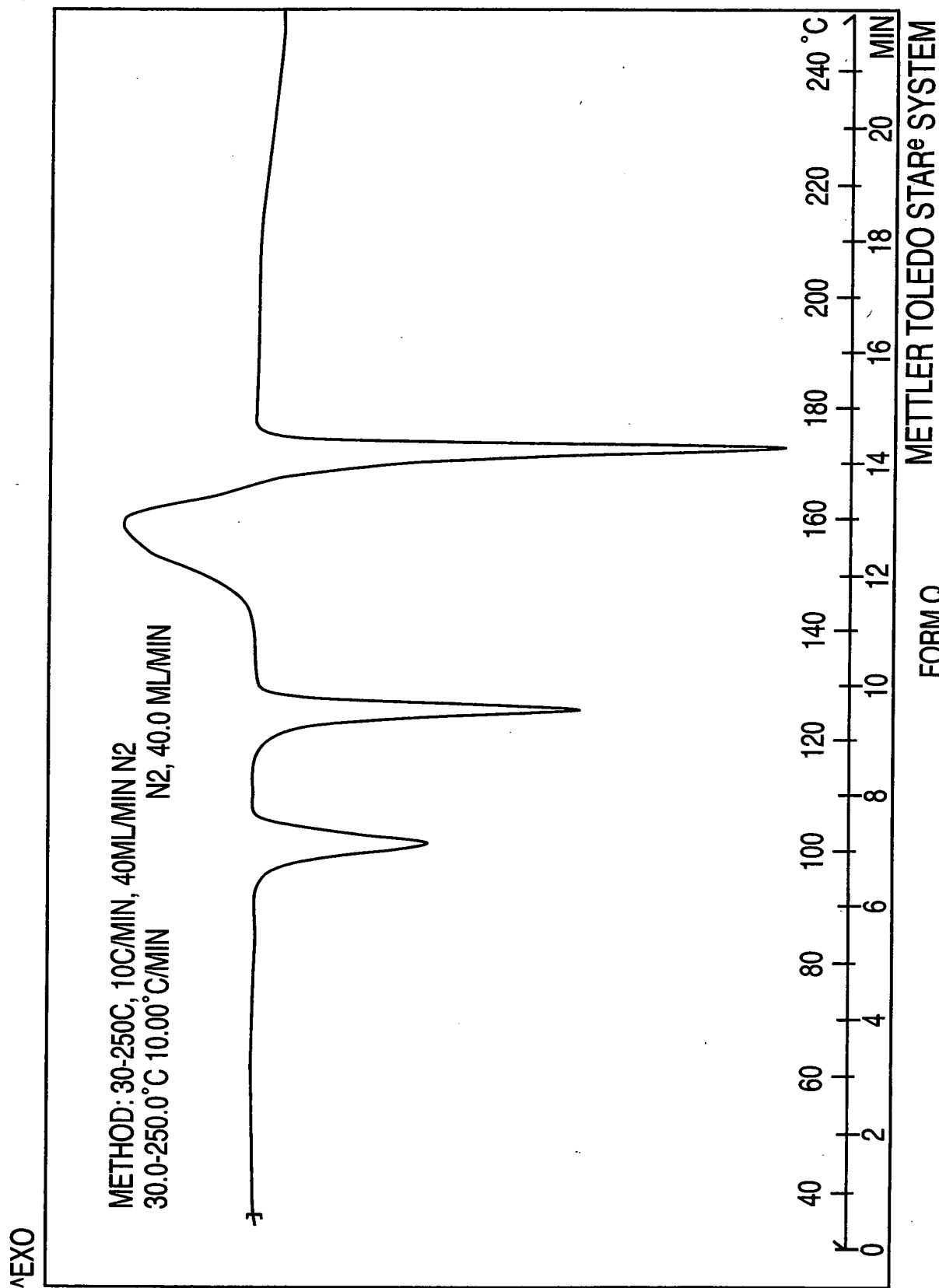


FIG. 49

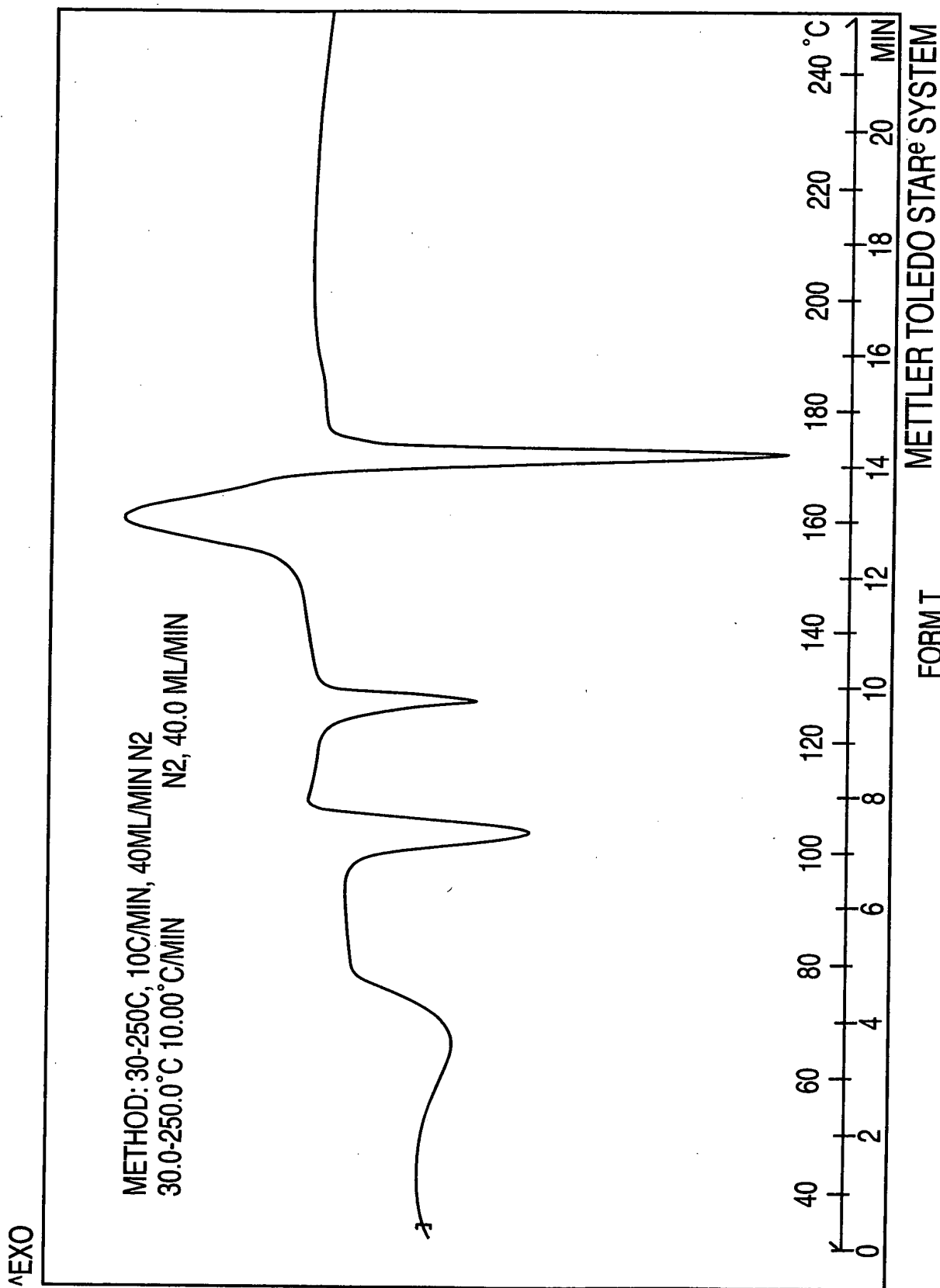


FIG. 50

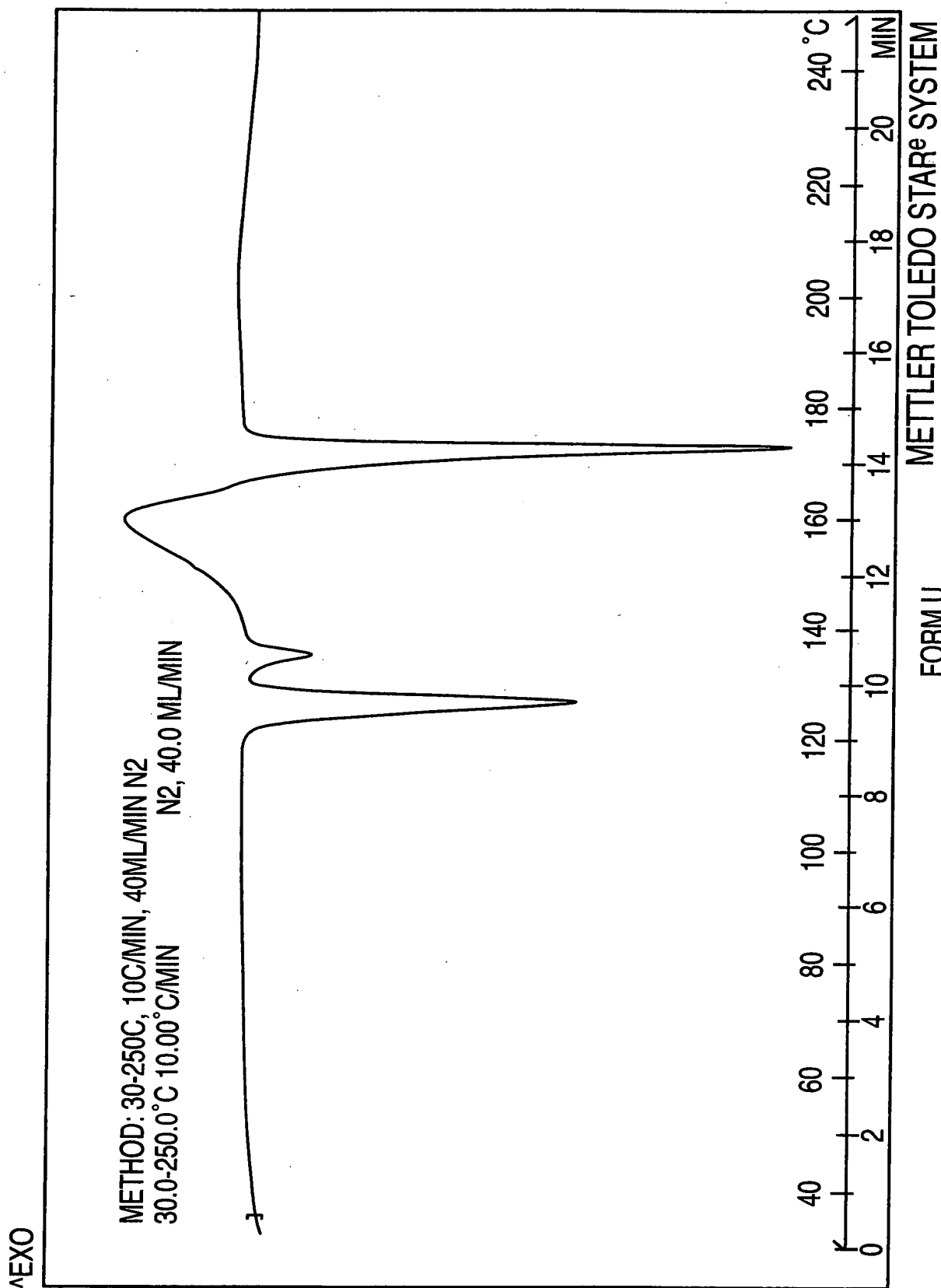


FIG. 51

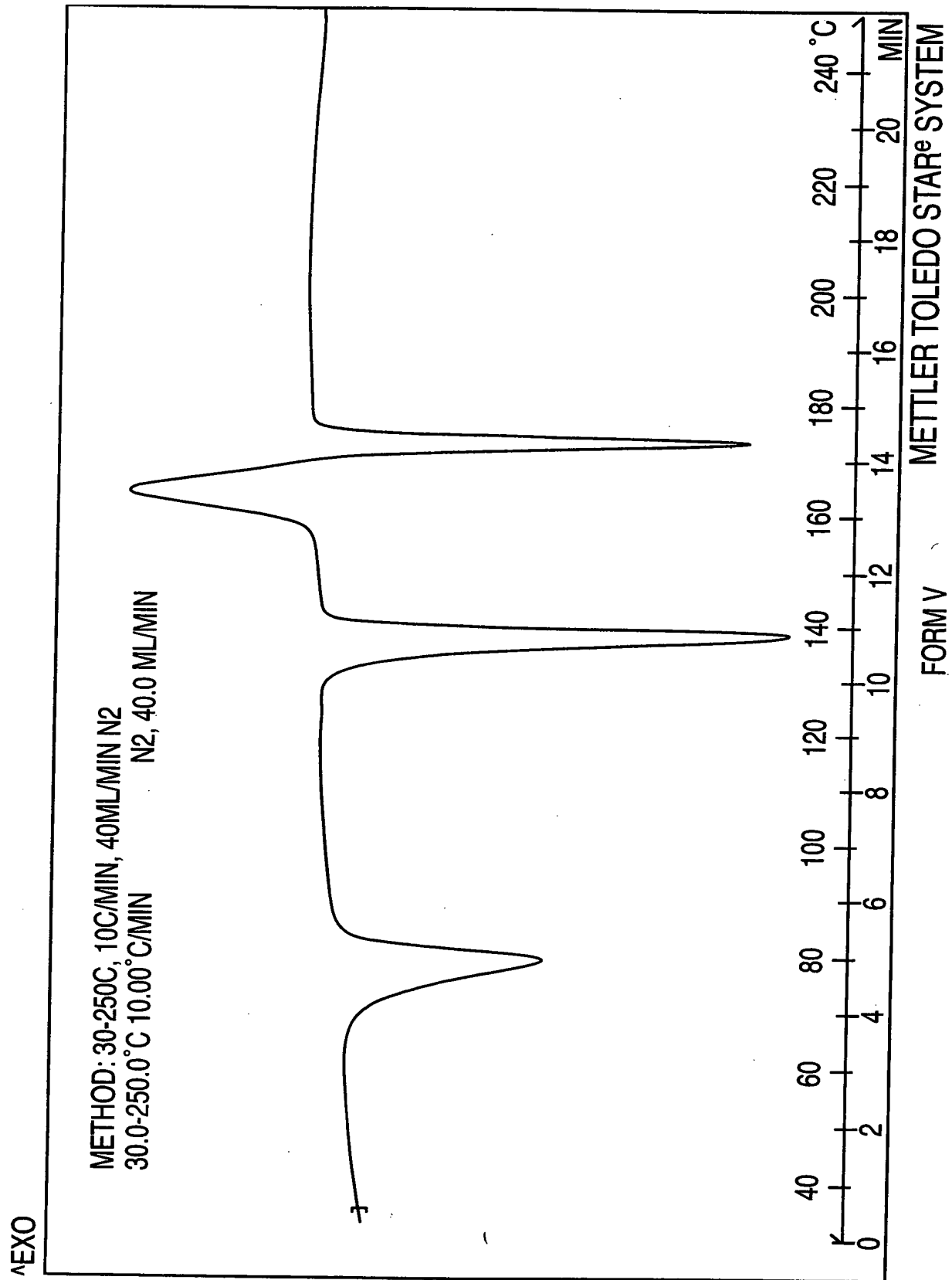


FIG. 52

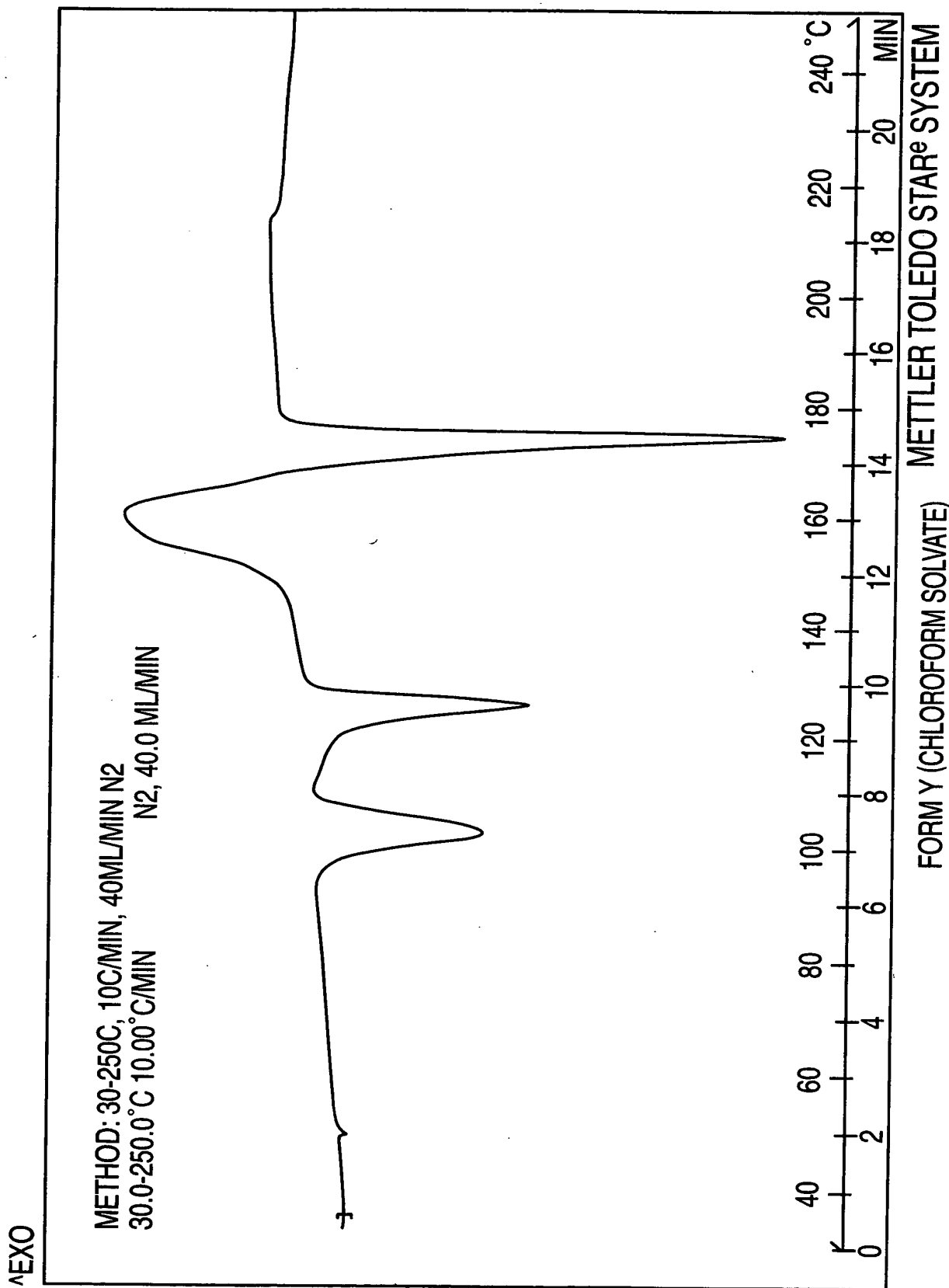


FIG. 53

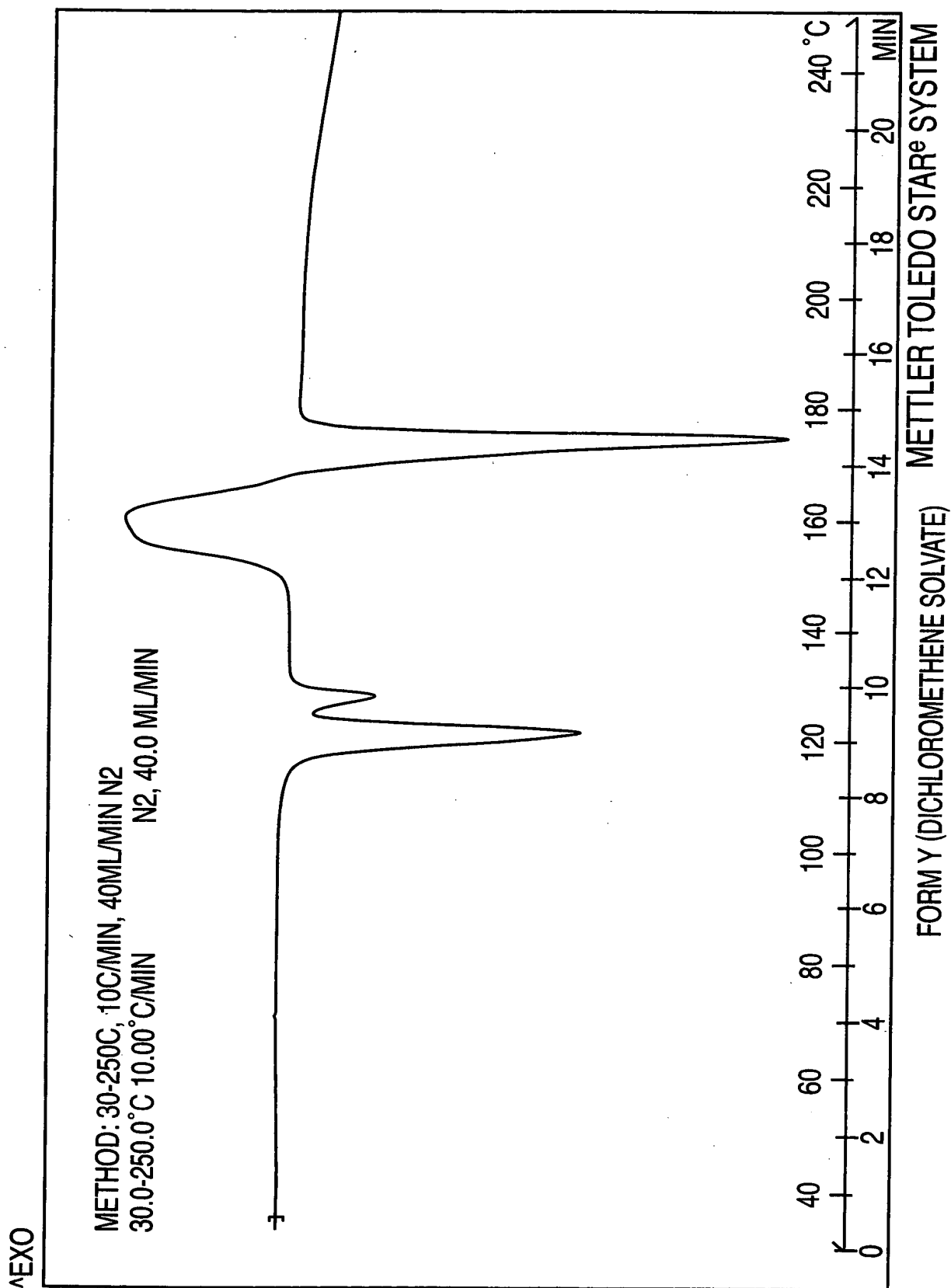
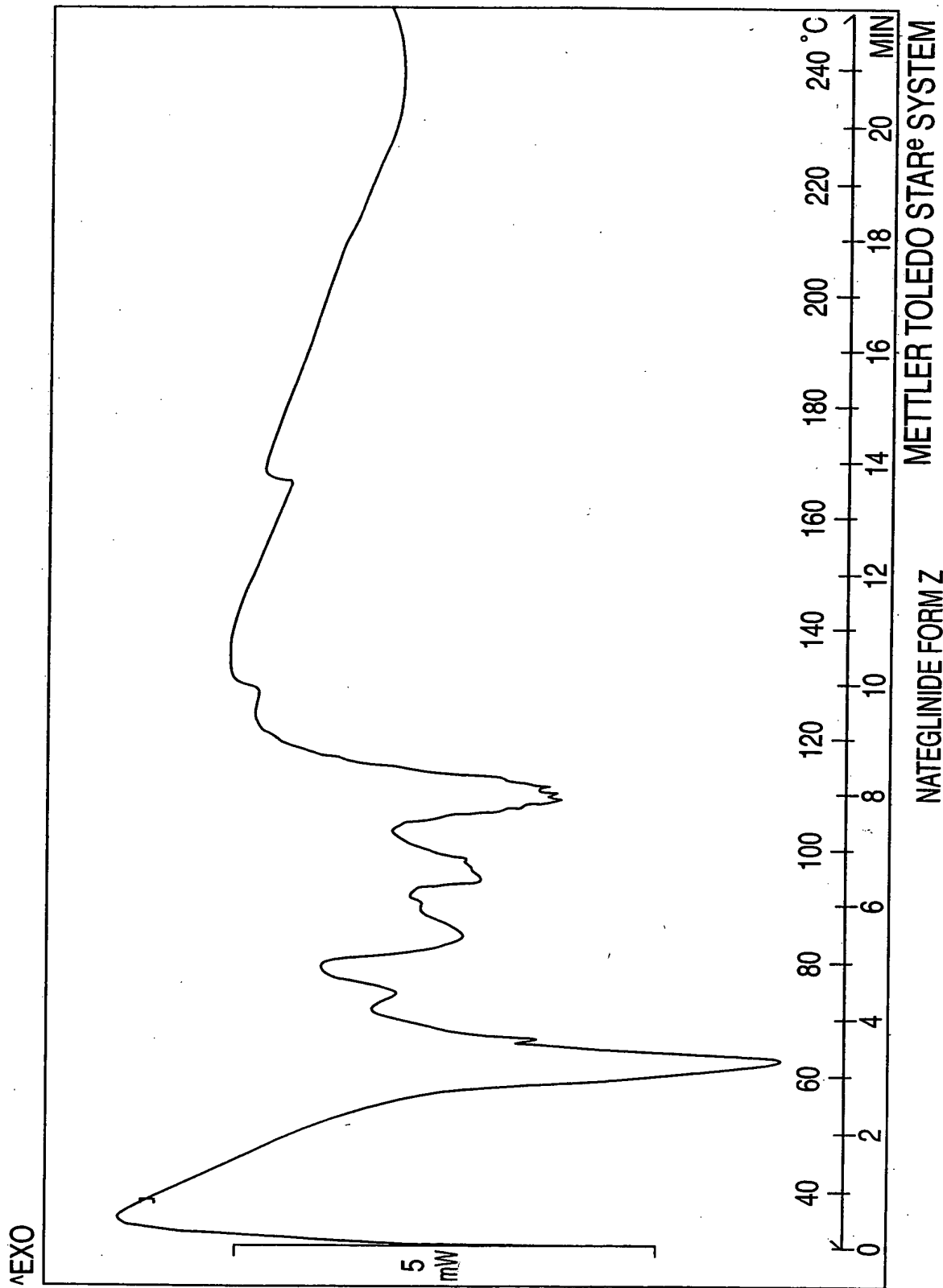
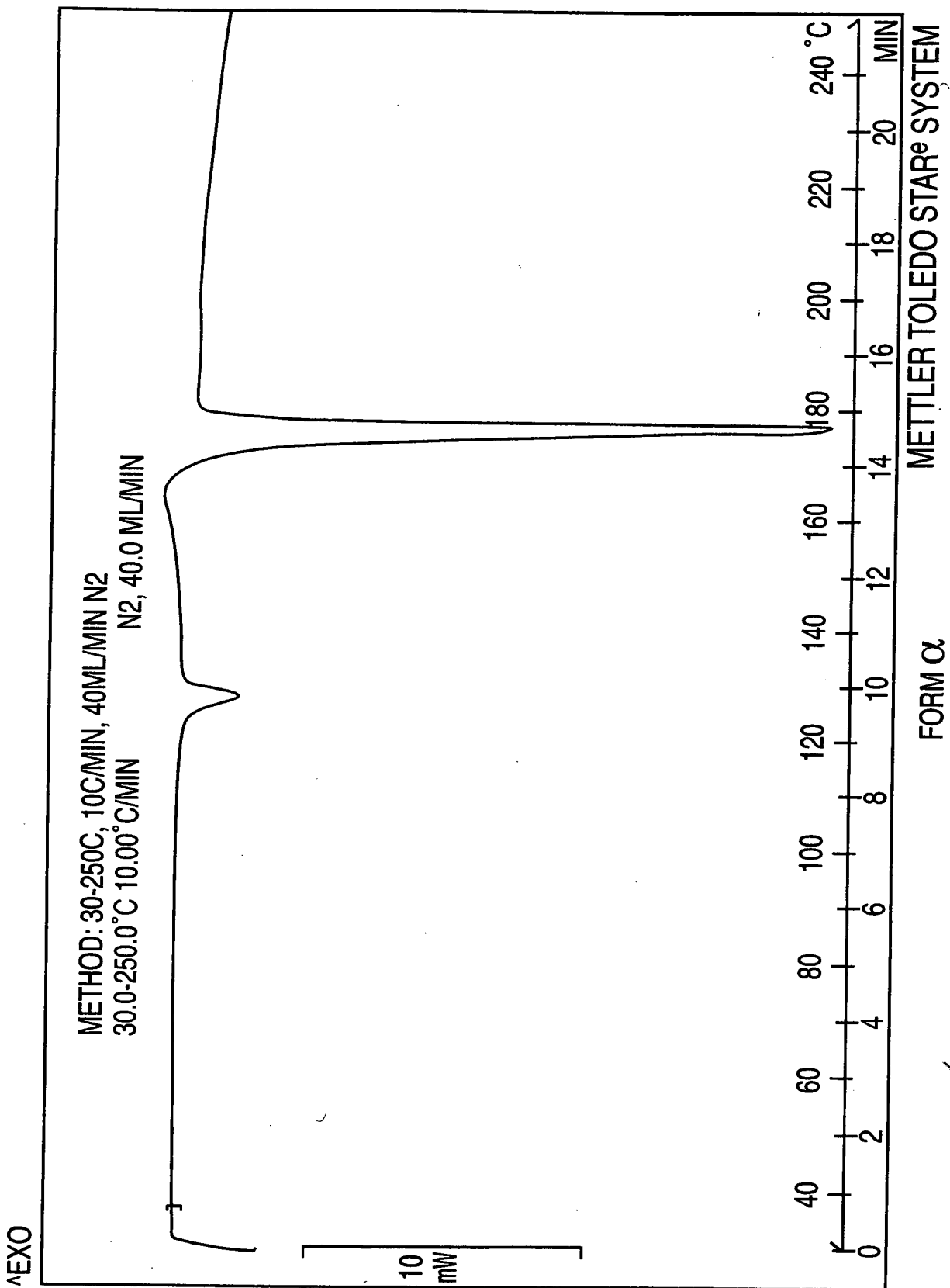


FIG. 54





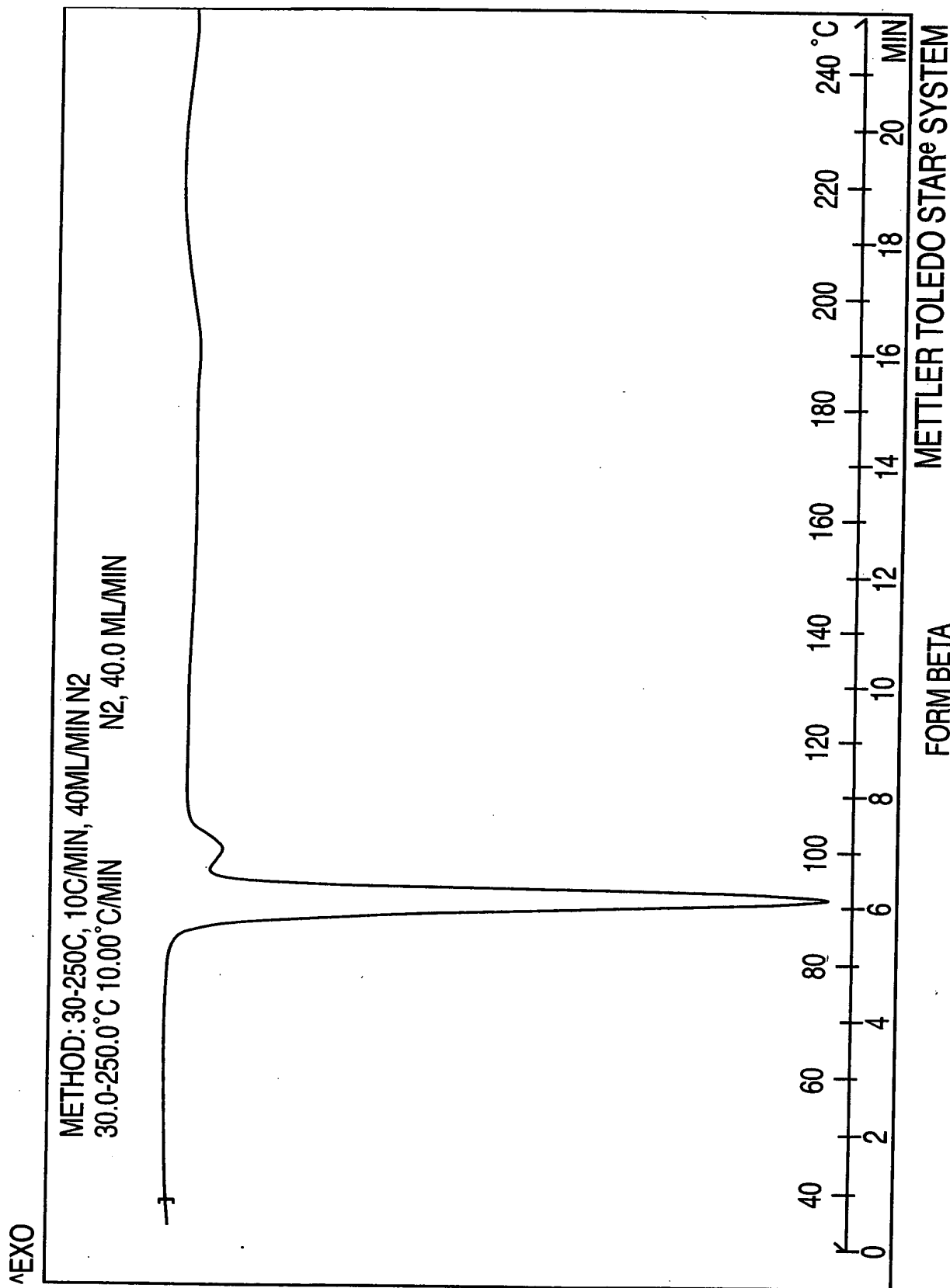


FIG. 57

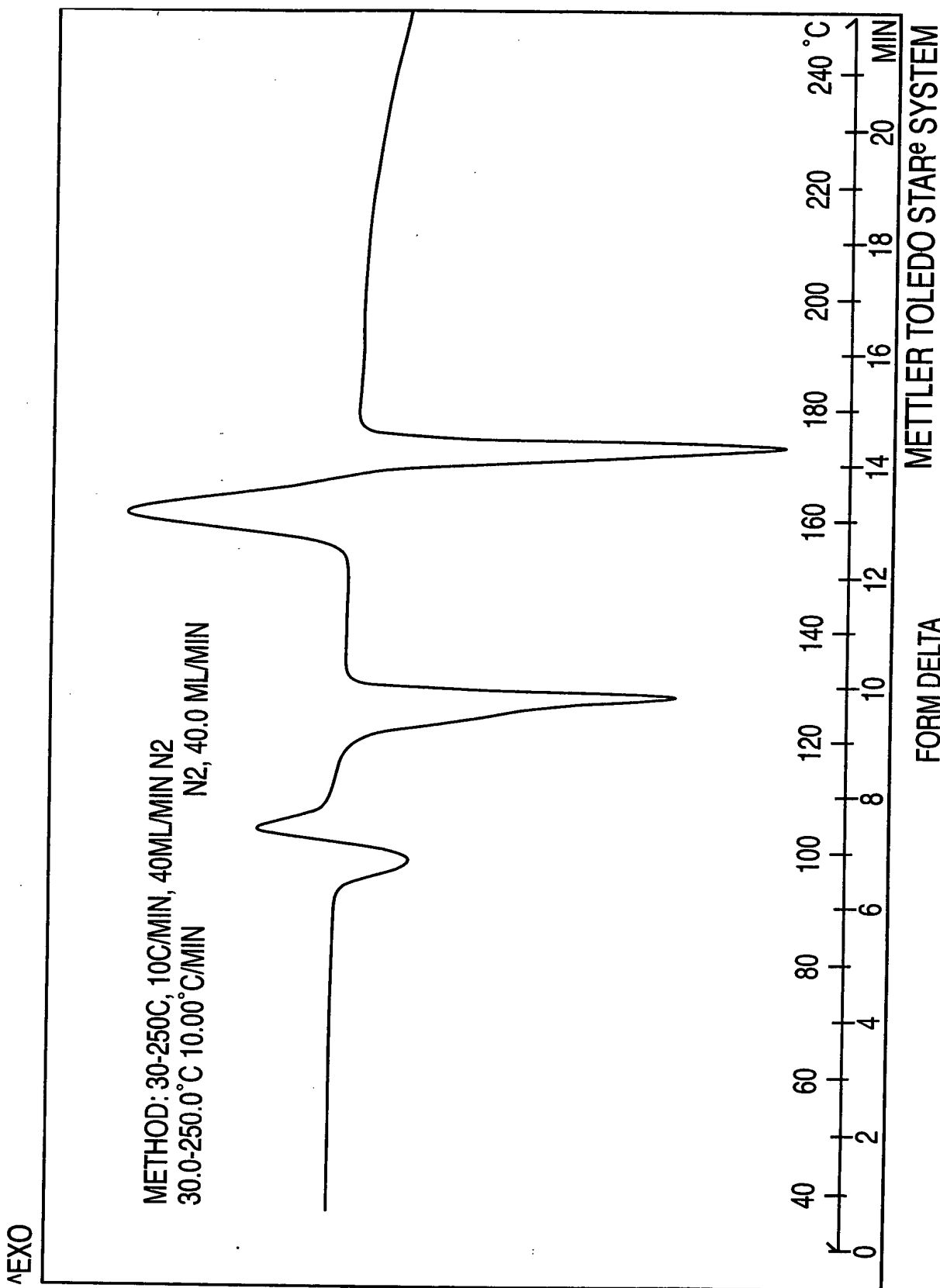


FIG. 58

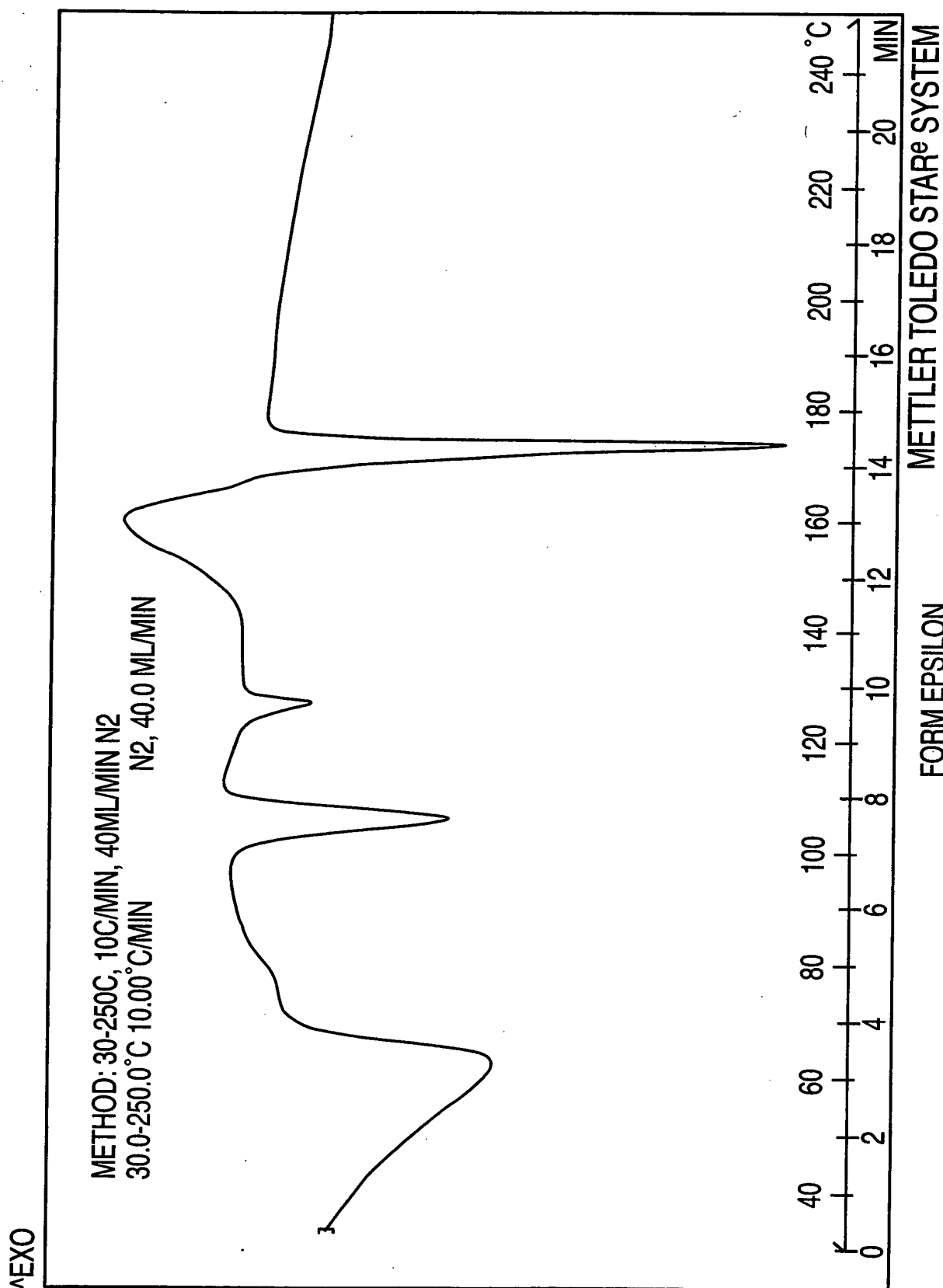
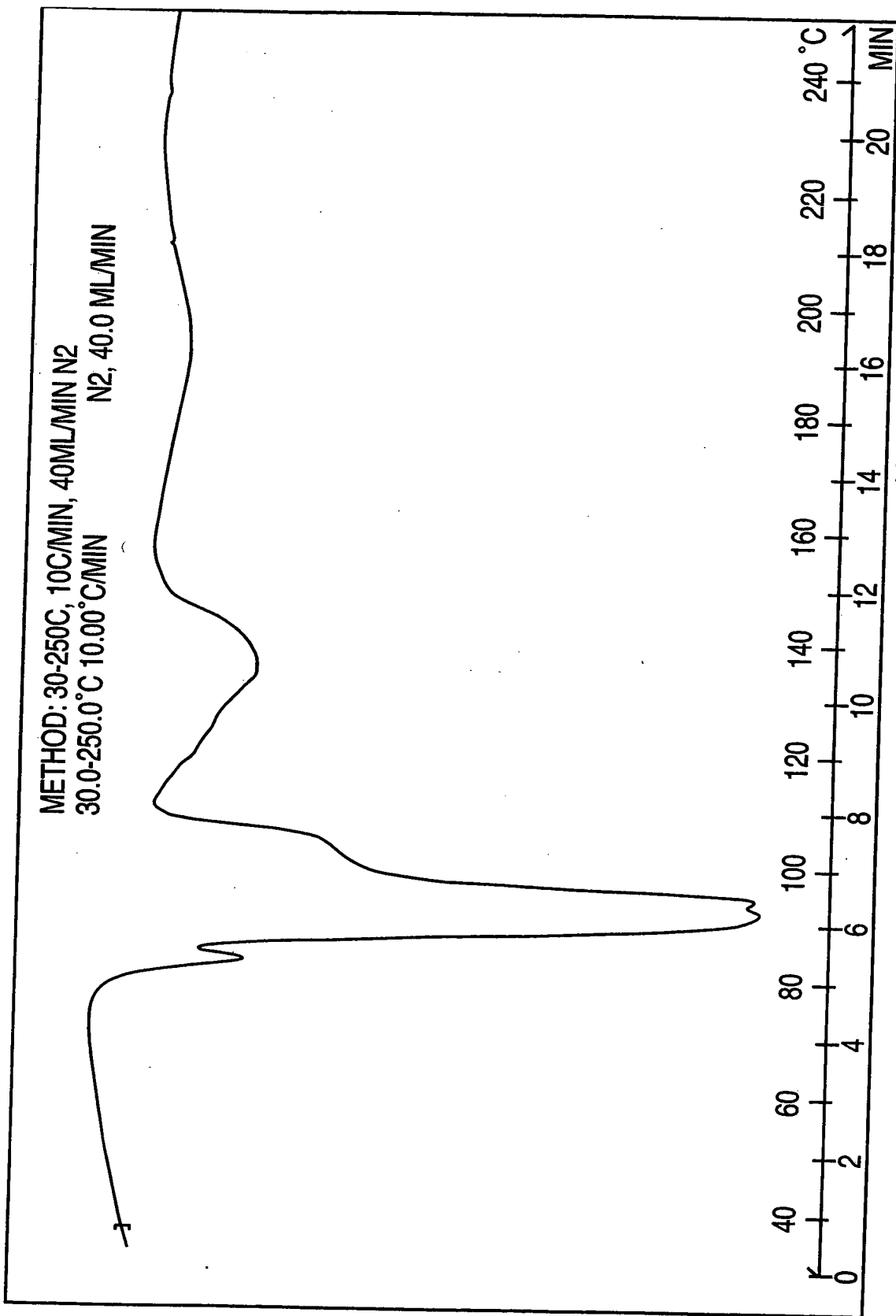


FIG. 59

^EXO



FORM GAMMA
METTLER TOLEDO STARE SYSTEM

FIG. 60

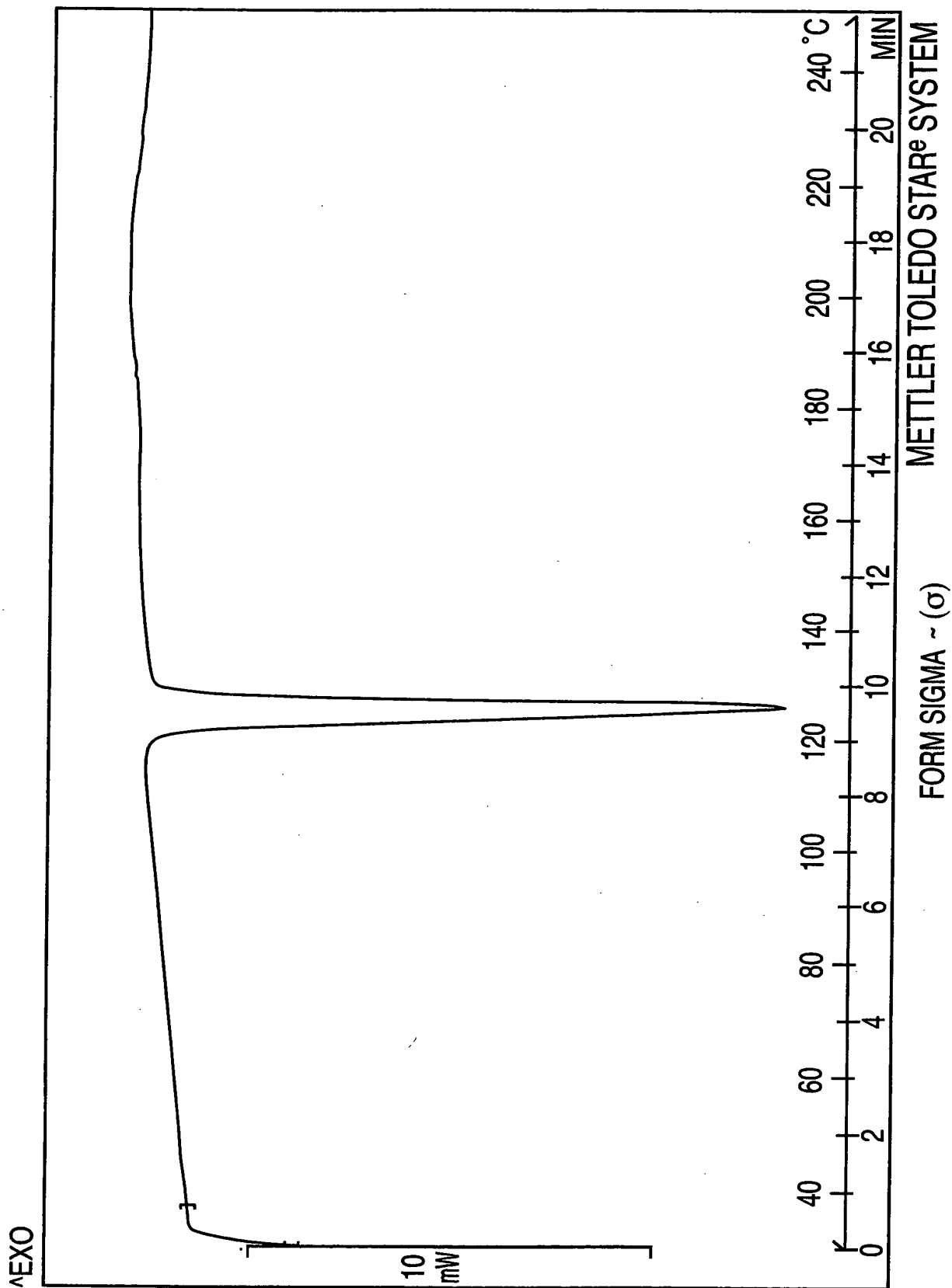


FIG. 61

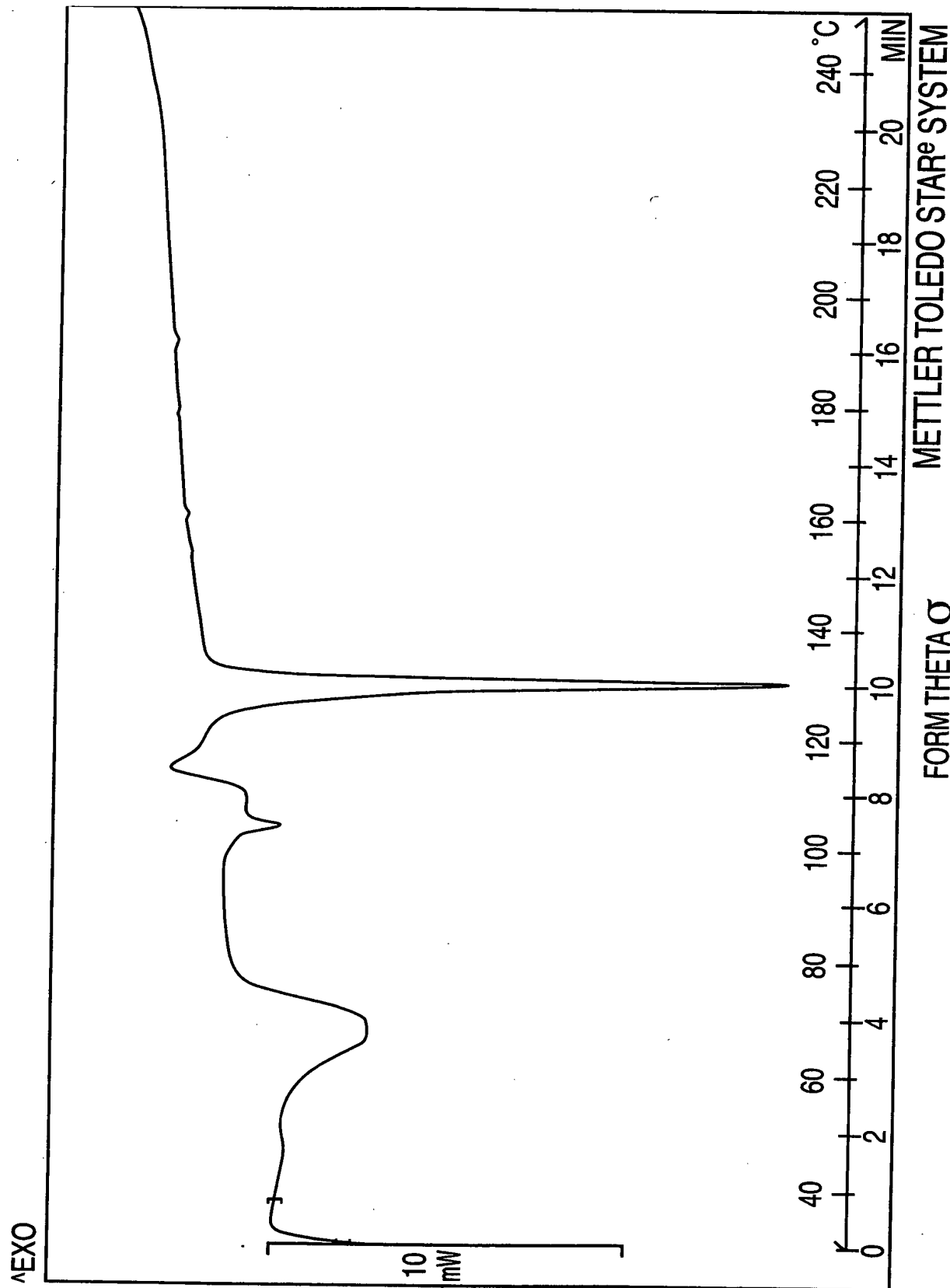


FIG. 62

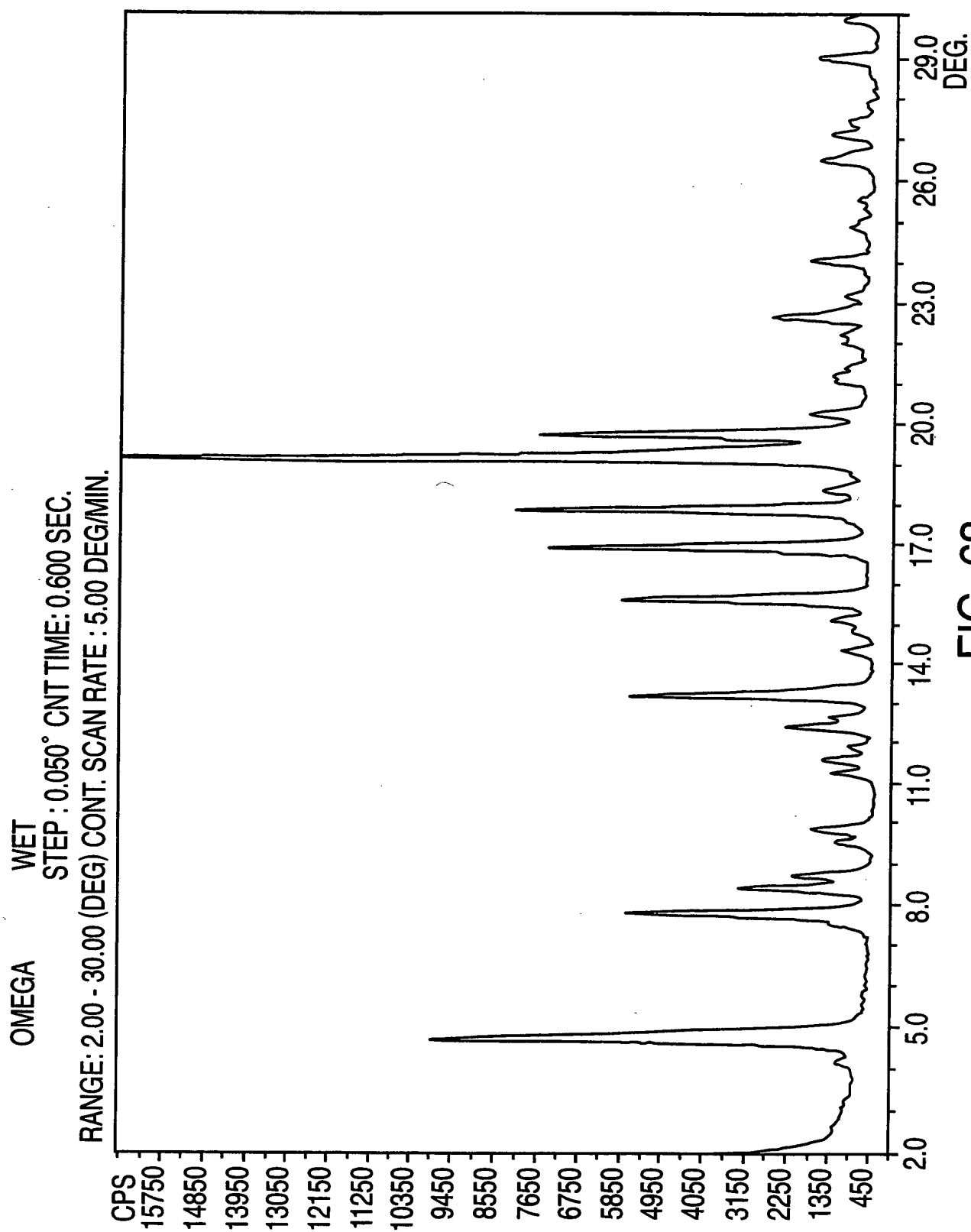


FIG. 63

Comparison between the impurity profile of Nateglinide crystallized in IPA-H₂O and Nateglinide in Methanol-H₂O

Sample No	Solvent	Impurity profile by RRT [% w/w]							
		D-PA (0.23)	(0.25)	(0.46)	(0.80)	Ipcha (0.89)	Dimer (1.38)	Methyl Ester (1.51)	Isopropyl Ester (2.3)
RL-2155/1	Methanol-H ₂ O	<0.01		0.02	<0.01	0.03	0.02	2.91	0.04
RL-2163/4	IPA-H ₂ O	<0.01	0.04		0.02	0.02	0.01		0.03
									0.02

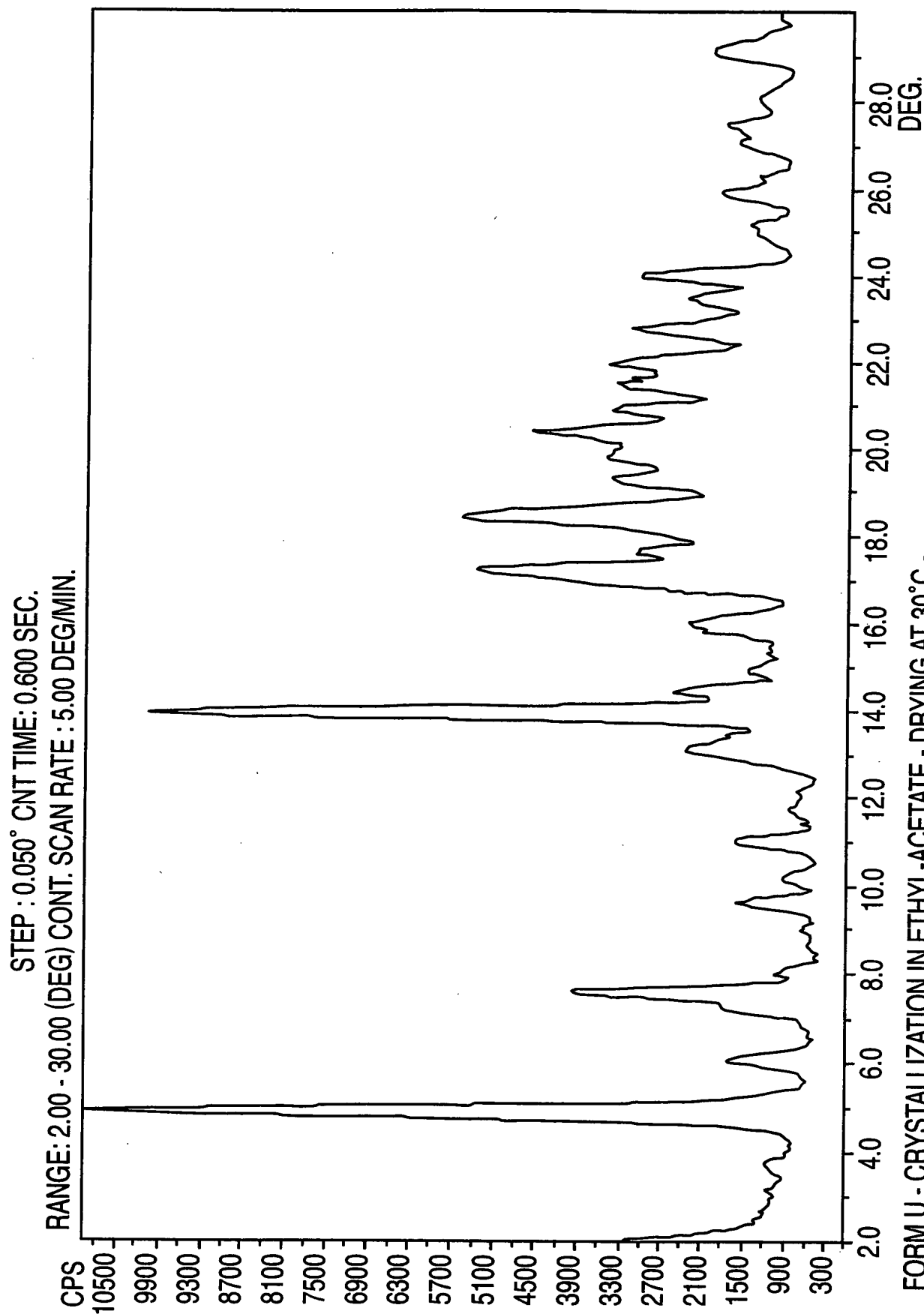
Note: D-PA means D-Phenyl Alanine

Ipcha means Iso propyl cyclohexyl carboxylic acid

Both are the starting materials of the product

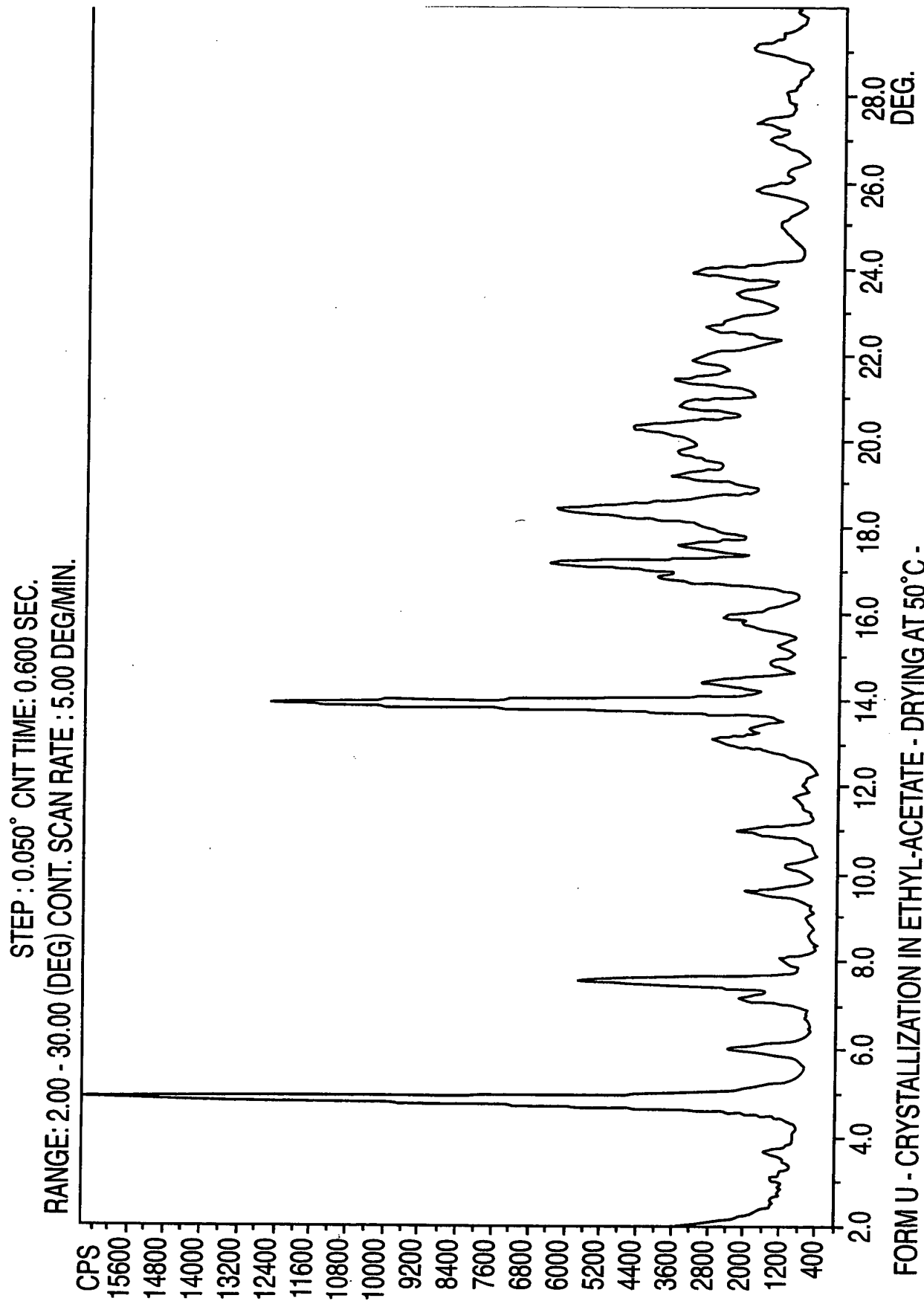
(-)-N-[(trans-4-isopropyl cyclohexane)carbonyl]-D-phenylalanine

FIG. 64



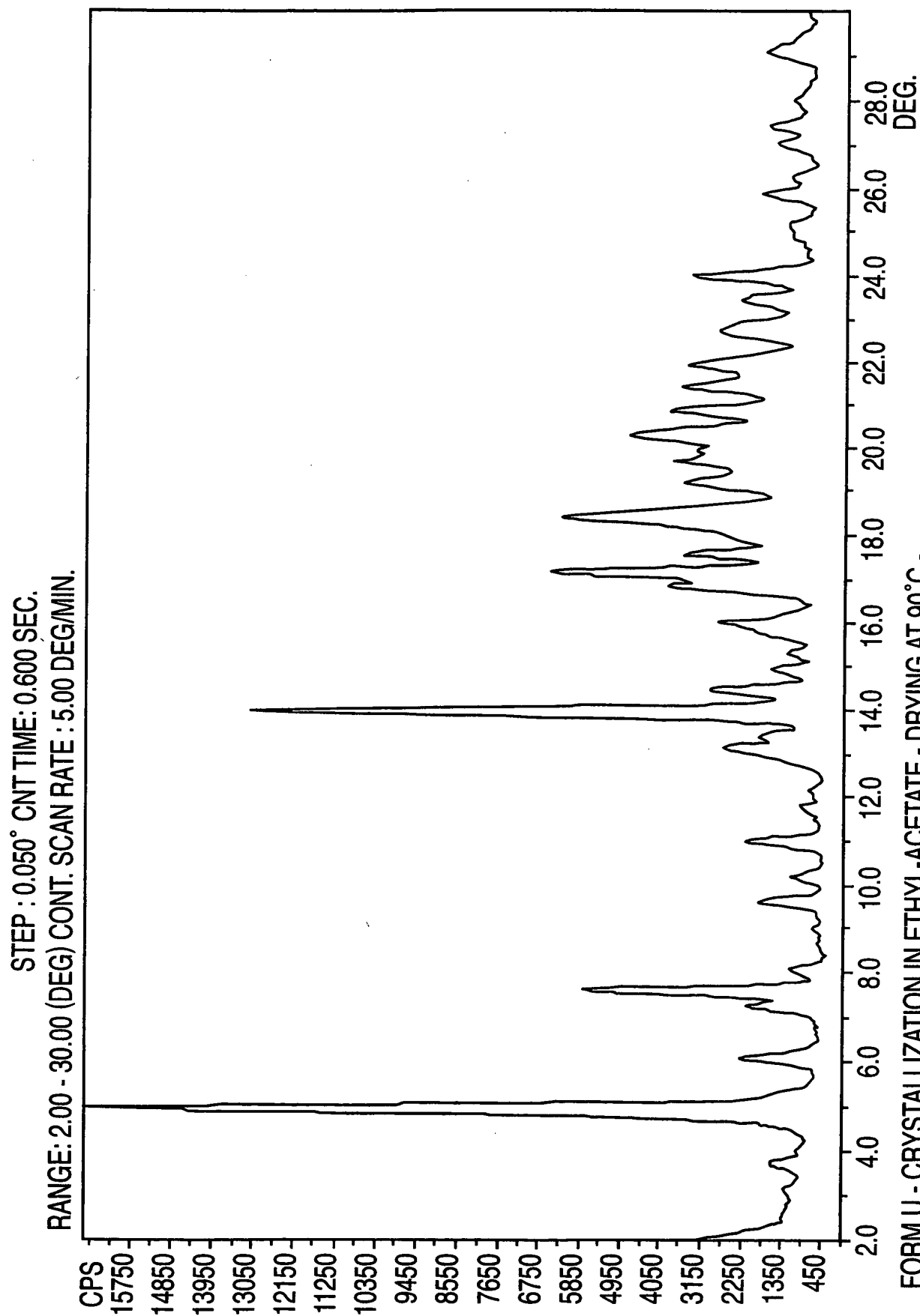
FORM U - CRYSTALLIZATION IN ETHYL-ACETATE - DRYING AT 30°C -
SAMPLE PREPARED ACCORDING TO EXAMPLE 17

FIG. 65



FORM U - CRYSTALLIZATION IN ETHYL-ACETATE - DRYING AT 50°C -
SAMPLE PREPARED ACCORDING TO EXAMPLE 17

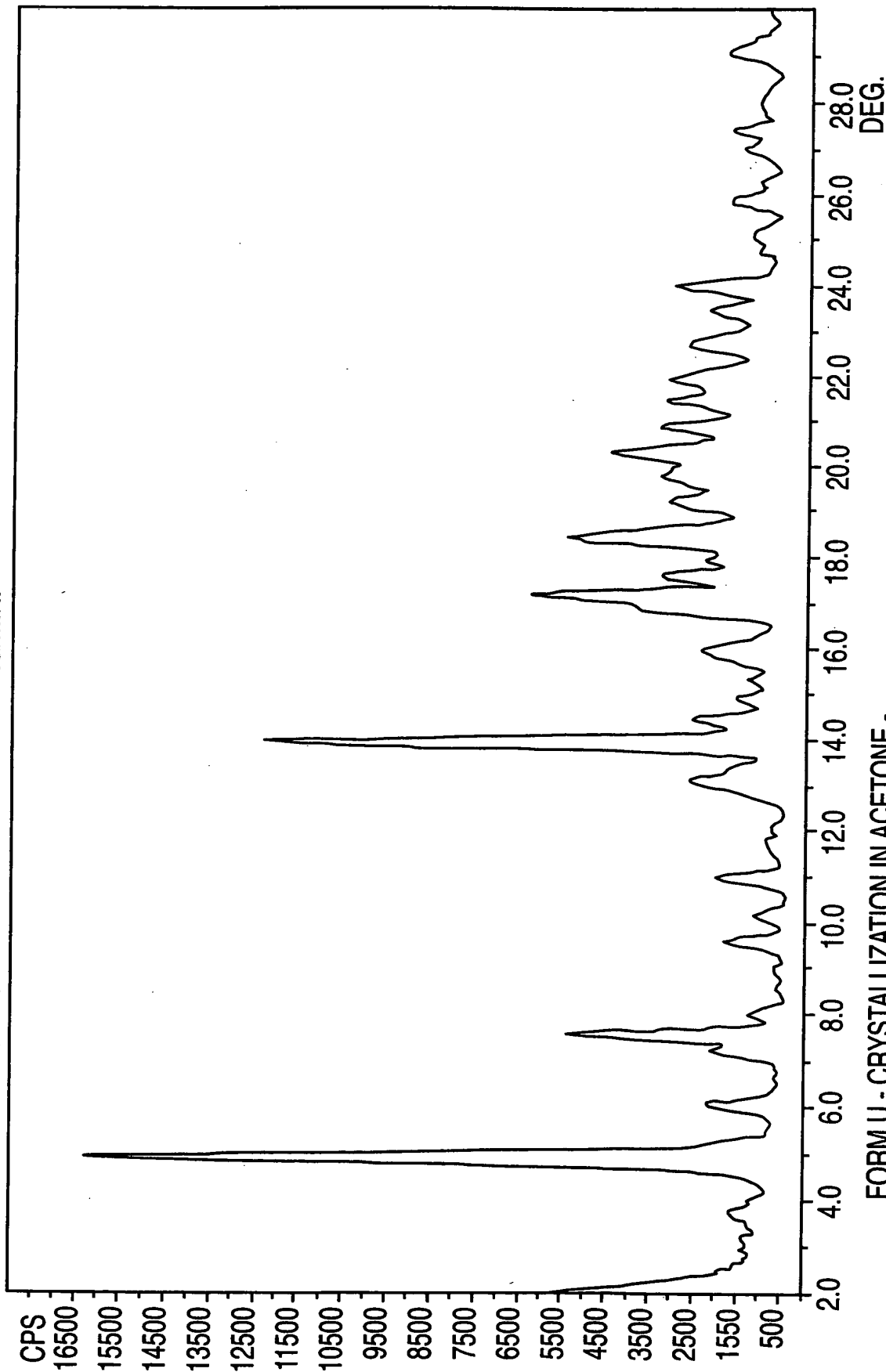
FIG. 66



FORM U - CRYSTALLIZATION IN ETHYL-ACETATE - DRYING AT 90°C -
SAMPLE PREPARED ACCORDING TO EXAMPLE 17

FIG. 67

STEP: 0.050° CNT TIME: 0.600 SEC.
RANGE: 2.00 - 30.00 (DEG) CONT. SCAN RATE: 5.00 DEG/MIN.



FORM U - CRYSTALLIZATION IN ACETONE -
SAMPLE PREPARED ACCORDING TO EXAMPLE 17

FIG. 68